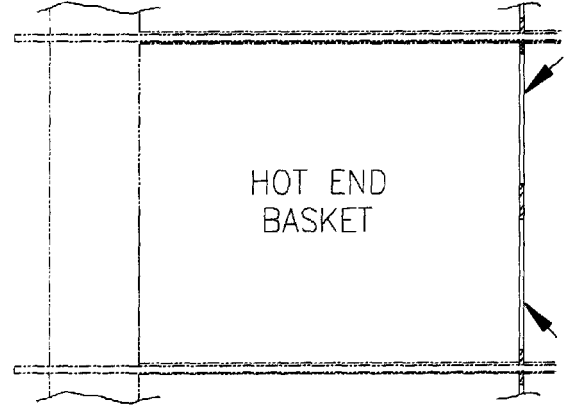


FINAL DRAWING PACKAGE

NOTES TO ERECTOR:
 ER-1) AFTER INSTAL
 BETWEEN HO
 ER-2) TRIM SEALING
 ER-3) INSTALL HOT

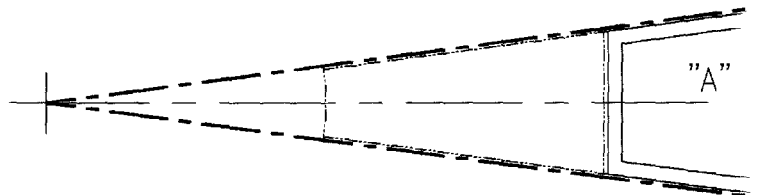
D



C

SECTION "

B



1

A

H				
G				
F				
E				
D				
C				
B				
A				
MARK	DATE	DR.	CK.	COMMENTS

ALTERATIONS



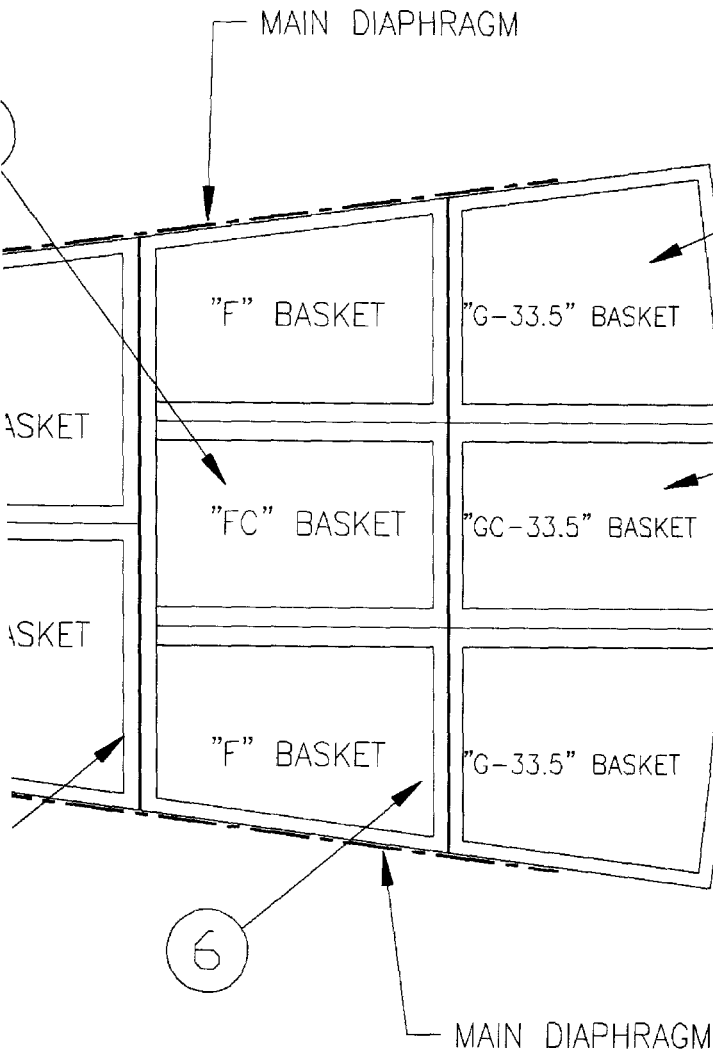
BILL OF MATERIAL				
REF. NO.	REQ'D.	MAT'L.	DESCRIPTION	SL
1	24		"A" BASKET SEALING BAR ASSEMBLY	SL
2	24		"B" BASKET SEALING BAR ASSEMBLY	SL
3	48		"C" BASKET SEALING BAR ASSEMBLY	SL
4	48		"D" BASKET SEALING BAR ASSEMBLY	SL
5	48		"E" BASKET SEALING BAR ASSEMBLY	SL
6	48		"F" BASKET SEALING BAR ASSEMBLY	SL
7	24		"FC" BASKET SEALING BAR ASSEMBLY	SL
8	48		"G-33.5"-OUT BSK'T SEALING BAR ASS'Y	SL
9	24		"GC-33.5"-OUT BSK'T SEALING BAR ASS'Y	SL

D

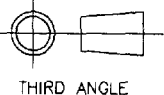

C

B

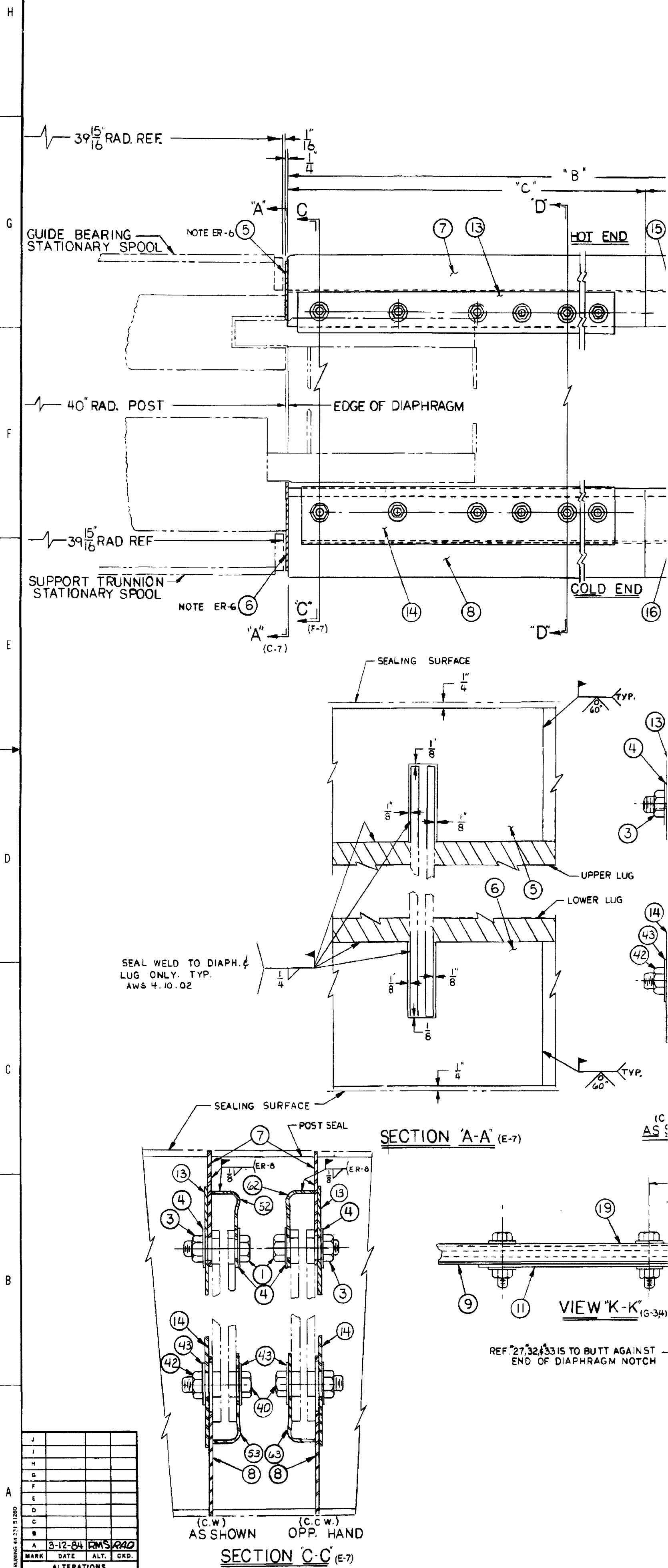
A



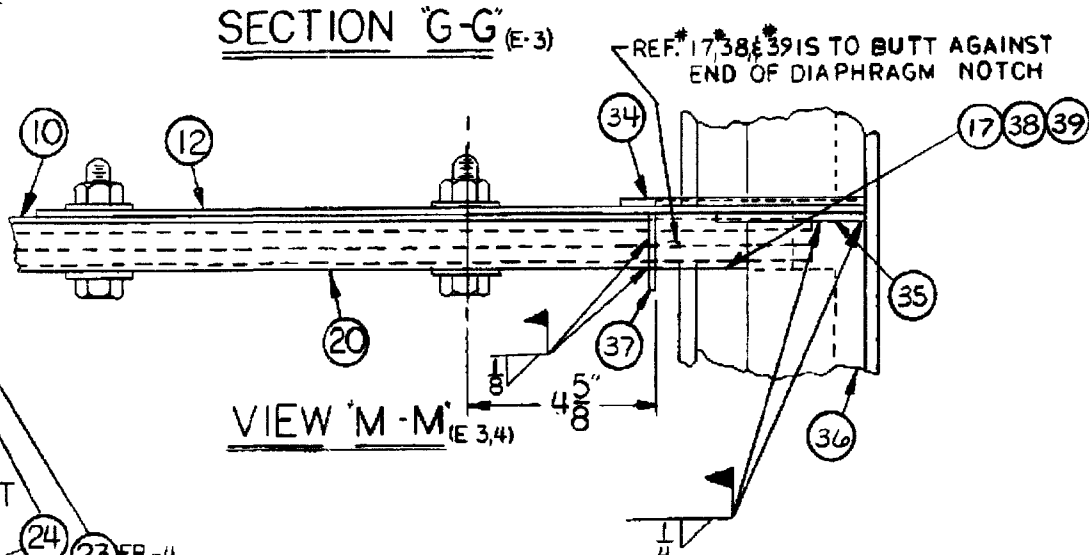
THIS DRAWING IS THE PROPERTY OF ABB AIR PREHEATER, INC AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF THE ABB AIR PREHEATER, INC

SUPERSEDES	SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	 THIRD ANGLE		 ABB AIR PREHEATER, INC. WELLSVILLE, NEW YORK			
		SUBJECT AIR PREHEATER		BASKET SEALING BAR ARRANGEMENT				
		API NO.						
		SIZE 33.5 V-VI						
		DR CU		CK CU		CODE	GROUP	SIZE
APPR BY		ER		0204	C	80030675		
DATE 12/11/03		SCALE NTS		WT		SHEET		OF

TABULATION											
ASS'Y. REQ'D.	ASS'Y. NO.	HEATER SIZE	DIM. "A"	DIM. "B"	DIM. "C"	TAB. "F"	TAB. "G"	TAB. "H"	TAB. "I"	TAB. "J"	ASS'Y. NO.
	1	32-1/2	286-1/2"	246-1/4"	23-1/4"	648	792	1584	1	1	1
	2	33	300-1/2"	260-1/4"	37-1/4"	696	840	1680	2	2	2
	3	33-1/2	314-1/2"	274-1/4"	51-1/4"	720	864	1728	3	3	3



62	
63	



IP7 033795

BILL OF MATERIAL					
DRAWING NO.	REQ D.	MAT L.	DESCR PT ON	SL	LOFT
P-18-25404	TAB"E"	3201	5/8" x 2-1/4" HEX. HD. CAPSCREW	SL	
P-14-25404	144	3201	5/8" x 1-3/4" HEX. HD. CAPSCREW	SL	
P-10-25412	TAB"F"	3205	5/8" HEX NUT	SL	
P-10-25413	TAB"G"	3214	5/8" WASHER	SL	
D-69637	4		ROTOR POST SEAL (HE)	SL	
D-69009	4		ROTOR POST SEAL (CE)	SL	
-TAB"L"-69636	24		INBOARD RADIAL SEAL LEAF (HE)	SL	
-TAB"L"-67790	24		INBOARD RADIAL SEAL LEAF (CE)	SL	
C-67511	96		OUTBOARD RADIAL SEAL LEAF (HE)	SL	
C-1-67791	24		OUTBOARD RADIAL SEAL LEAF (CE)	SL	
C-75389	24		OUTBOARD SEAL TAB (HE)	SL	
C-2-67953	24		OUTBOARD SEAL TAB (CE)	SL	
-TAB"L"-67795	24		INBOARD HOLDING STRIP (HE)	SL	
-TAB"L"-78083	24		INBOARD HOLDING STRIP (CE)	SL	
D-2-67524	72		HOLDING STRIP (HE)	SL	
D-2-78084	72		HOLDING STRIP (CE)	SL	
-17-78077	1	4011	3/8" x 4" x 60"	SL	
E-67521	192		SPACER BAR	SL	
C-67517	96		OUTBOARD DIAPH. SEAL (HE)	SL	
D-77033	96		OUTBOARD DIAPH. SEAL (CE)	SL	
E-67800	24		"T" BAR TAB	SL	
E-67540	24		"T" BAR TAB	SL	
B-66281	24		"T" BAR ASS'Y. ASS'Y*(TAB"L")	SL	
E-65538	48		CLIP	SL	
E-1-67526	24		END PLATE	SL	
C-52965	1/CONT		RADIAL SEAL STRAIGHT EDGE ASS'Y, ASS'Y*(TAB"M")	SL	
H-27-78077	1	5102	3/8" x 4" x 60"	SL	
H-28-78077	24	4211	*12 GA. x 1-1/16" x 1-5/8"	SL	
C-2-67791	24		OUTBOARD RADIAL SEAL LEAF (CE)	SL	
C-3-67791	24		OUTBOARD RADIAL SEAL LEAF (CE)	SL	
C-4-67791	24		OUTBOARD RADIAL SEAL LEAF (CE)	SL	
H-32-78077	1	5102	1/4" x 4" x 60"	SL	
H-33-78077	1	5102	1/2" x 4" x 60"	SL	
E-77345	24		"T" BAR TAB	SL	
E-77351	24		"T" BAR TAB	SL	
B-77352	24		"T" BAR ASS'Y. # TAB "L"	SL	
E-1-68708	24		END PLATE	SL	
H-38-78077	1	4011	1/4" x 4" x 60"	SL	
H-39-78077	1	4011	1/2" x 4" x 60"	SL	
P-18-31500	TAB"E"	3201	5/8" x 2-1/4" HEX. HD. BOLT	SL	
P-14-31500	144	3201	5/8" x 1-3/4" HEX. HD. CAPSCREW	SL	
P-10-1420	TAB"F"	3205	5/8" HEX NUT	SL	
P-6-1289	TAB"G"	3221	5/8" LOW ALLOY-FLAT WASHER	SL	
D-1-78084	24		HOLDING STRIP (CE)	SL	
D-1-67524	24		HOLDING STRIP (H.E.)	SL	


THE FOLLOWING TO BE USED FOR CLOCKWISE ROTATION				
D-TAB"L"-67809	24		INBOARD DIAPH. SEAL H.E. (AS SHOWN)	SL
D-TAB"L"-67811	24		INBOARD DIAPH. SEAL C.E. (AS SHOWN)	SL

THE FOLLOWING TO BE USED FOR COUNTER-CLOCKWISE ROTATION				
D-TAB"L"-67810	24		INBOARD DIAPH. SEAL H.E. (OPP. HAND)	SL
D-TAB"L"-67812	24		INBOARD DIAPH. SEAL C.E. (OPP. HAND)	SL

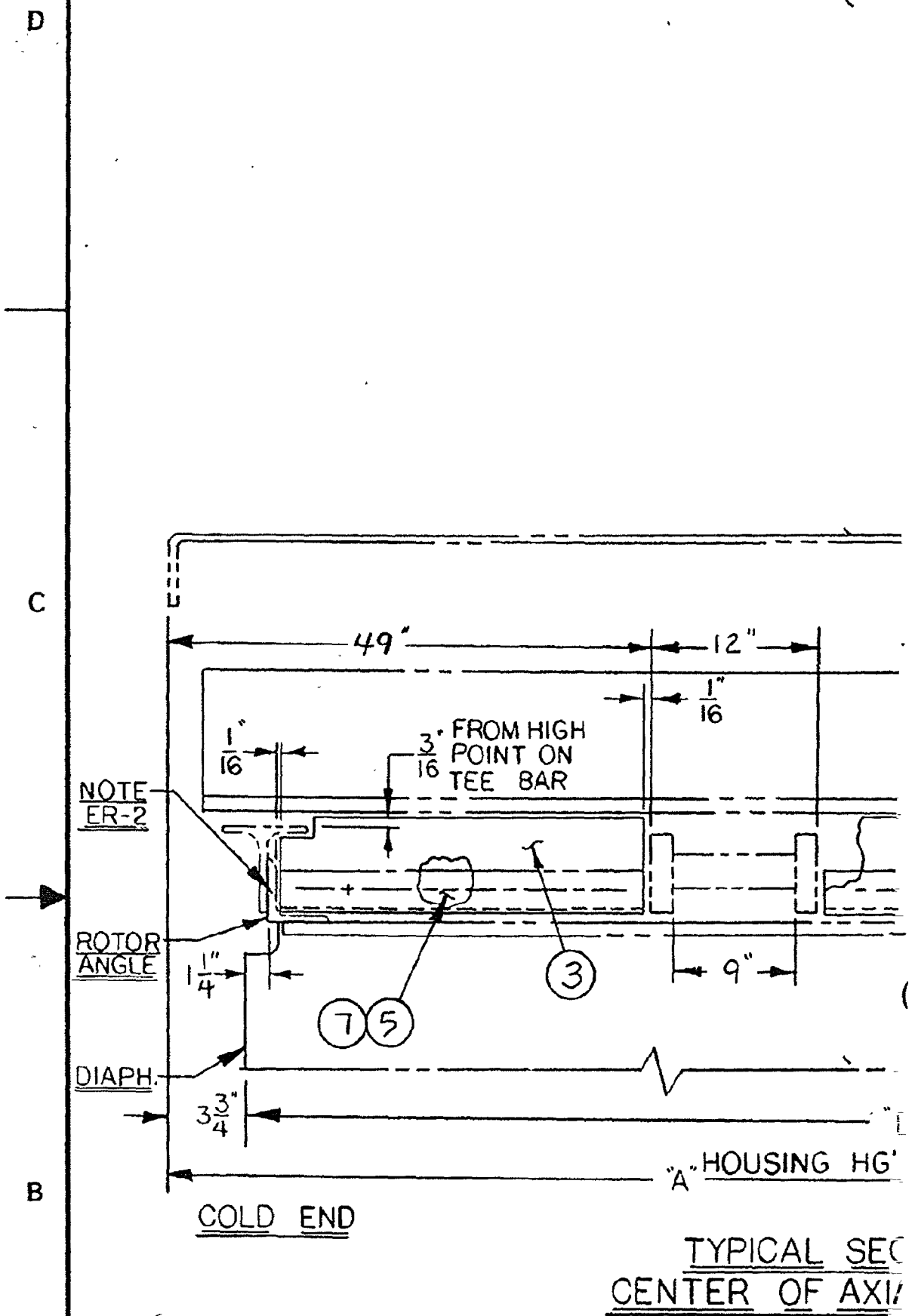
TO ERECTOR:
ALL BOLTS, NUTS AND WASHERS TO BE INSTALLED EXACTLY AS SHOWN.
FOLLOW INSTRUCTIONS ON "SEAL INSTALLATION AND SETTING DRAWING", GROUP #2105.
ON HOT END DETERMINE HIGHEST DIAPHRAGM. MEASURE DISTANCE FROM CENTER OF OUTBOARD RADIAL SEAL BOLT HOLE TO MACHINED SURFACE OF SECTOR PLATE OR TO SEAL STRAIGHT EDGE. SUBTRACT 1" FROM THIS DIM. AND SET ALL HOT END "T" BARS SUPPORT ANGLES TO THIS DIM. FROM COLD END OF SAME DIAPHRAGM, MEASURE DISTANCE FROM CENTER OF OUTBOARD RADIAL SEAL BOLT HOLE TO MACHINED SURFACE OF SECTOR PLATE OR TO SEAL STRAIGHT EDGE. SUBTRACT 0" FROM THIS DIM. & SET SUPPORT ANGLES TO THIS DIM.. TOTAL VARIATION BETWEEN CONNECTING PL TO HOUSING SPLIT & THE "T" BAR SUPPORT ANGLE NOT TO EXCEED 1/4".
AFTER SUPPORT ANGLES ARE SET & WELDED IN PLACE, INSTALL ALL OF SPACERS (CUT TO FIT FROM REF. #17,27,32,33,38&39) BEFORE INSTALLING ROTOR "T" BARS.
INSTALL "T" BARS, REF. #23 & 36 WITH ENDS LOCATED ON CENTER LINES OF MODULES TO THE RADIUS SHOWN NOT EXCEEDING A TOTAL VARIATION OF 1/8". BOLT "T" BAR TO SUPPORT ANGLES. INSTALL CLIPS, REF. #24 & WELD AS SHOWN IN VIEW "L-L".
INSTALL ROTOR POST SEALS, REF. #5 TO CLEARANCE DIMENSION SHOWN & WELD AS SHOWN IN VIEW "A-A".
RECOMMENDED PROCEDURE FOR INSTALLING RADIAL SEALS:
7.1 STARTING AT OUTBOARD ENDS, LOCATE DIAPH. SPACER WITH SPACER HOLES CENTERED IN DIAPH.. TACKWELD TO ONE DIAPH. ONLY AS SHOWN. AT OUTBOARD AND INBOARD BOLT HOLES INSET BOLTS, REF. #1 & 40, WITH WASHER REF. #4 & 43, & DIAPH. SEAL, REF. #19 & #20, ON BOLT. INSTALL RADIAL SEAL LEAF SECTION FOLLOWED BY RADIAL SEAL TAB & HOLDING STRIP. BOLT ALL THE COMPONENTS TOGETHER WITH HEX NUTS, REF. #3 & 42, WITHOUT TIGHTENING. INSTALL REF. #1, #3, #4, #40, #42 & #43 IN THEIR PROPER LOCATION FOR THE REMAINING BOLT HOLES IN THE SECTION. DO NOT TIGHTEN. REPEAT THIS PROCEDURE FOR THE REMAINING SEAL LEAF SECTIONS. TRIM INBOARD SEALS TO FIT IF NECESSARY.
7.2 AFTER SEALS ARE INSTALLED AND SET TO STRAIGHT EDGE, TIGHTEN BOLTS.
7.3 LOCATE REF. #25 & #37 AND WELD TO REF. #17,19,20,27,32,33,38 & 39. LOCATE REF. #28 AND WELD AS SHOWN.
7.4 LOCATE REF. #21,22,34 & 35 AND WELD TO "T" BAR ONLY.
SEAL WELD END OF INBOARD RADIAL SEAL, REF. #7 & #8 & INBOARD DIAPHRAGM SEAL, REF. #52,53,62 & 63 (ACROSS TOP & DOWN SIDE) TO POST SEAL AS SHOWN.

THIS DRAWING IS THE PROPERTY OF THE AIR PREHEATER COMPANY AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF THE AIR PREHEATER COMPANY.

LAS. COLD END ~ DEF. SECT PL's.

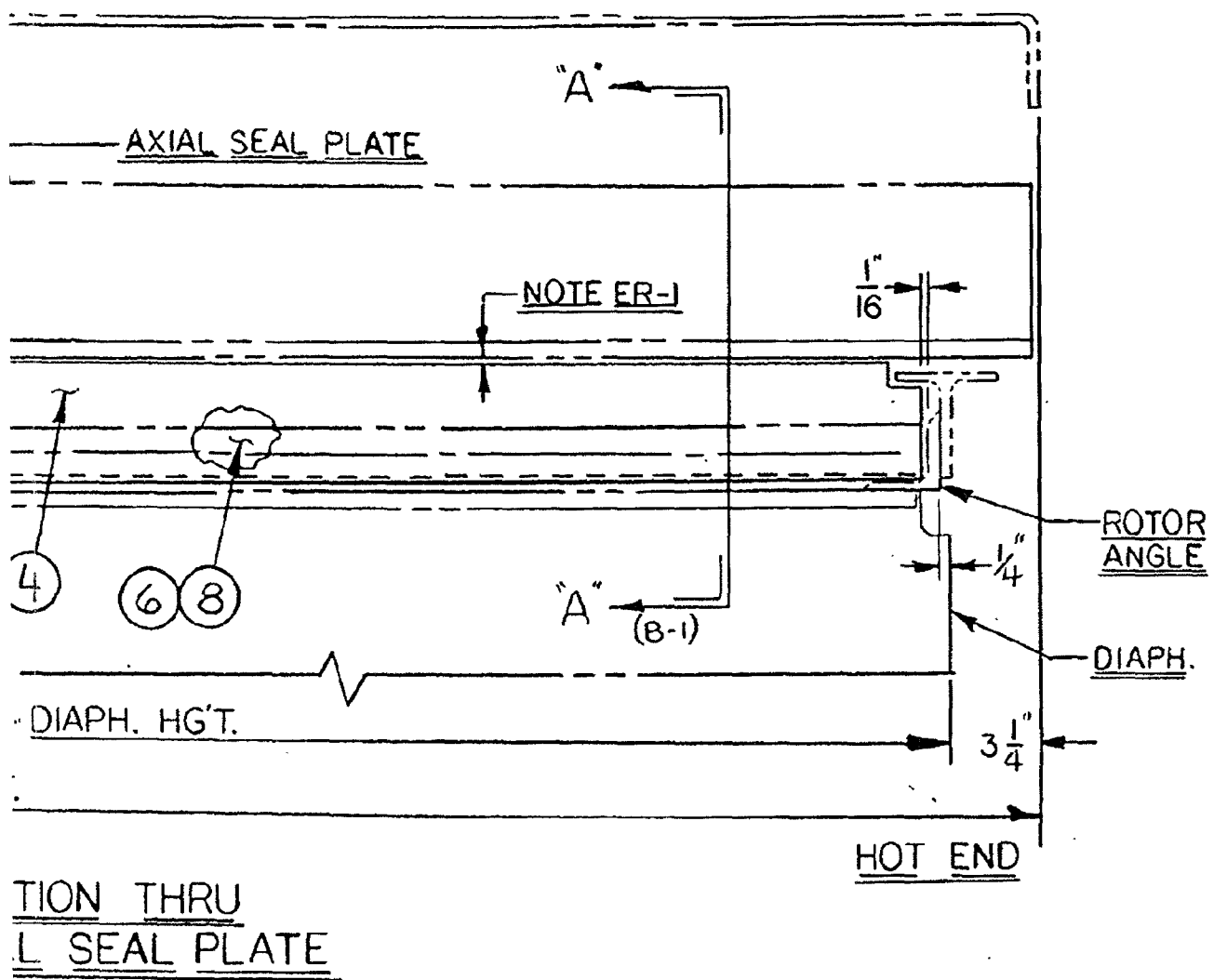
SUPERSEDED BY	Subject	AIR PREHEATER		 AIR PREHEATER CE AIR PREHEATER WELLSVILLE, NEW YORK	
	Model / Arr't	MOD			
	Size, Type Series	32-1/2 - 33-1/2 VI			
	Des.	Ch.			
SUPERSEDES	Dr.	KAT	Ch.	DV	RADIAL SEAL ASS'Y. (5/16" DIAPH.)
	Tr.		Ch.		
	Material				
	Std. No.				
	DATE	3-16-83	SCALE	NTS	
	CODES	80509			
	GROUP	0103	SIZE	H	
	NUMBER	78077		ISSUE	A
	WT.	SHEET		OF	

TABULATION										
ASS'Y. REQ'D.	ASS'Y. NO.	TAB "A"	TAB "B"	TAB "C"	TAB "E"	TAB "F"	TAB "G"	TAB "H"	APPROX. WGT.	ASS REQ
	1	105"	98"	336	1	2	7	8		
	2									
	3									



J			
I			
H			
G			
F			
E			
D			
C			
B			
A			
MARK	DATE	ALT.	CKD.
ALTERATIONS			

Y
D.



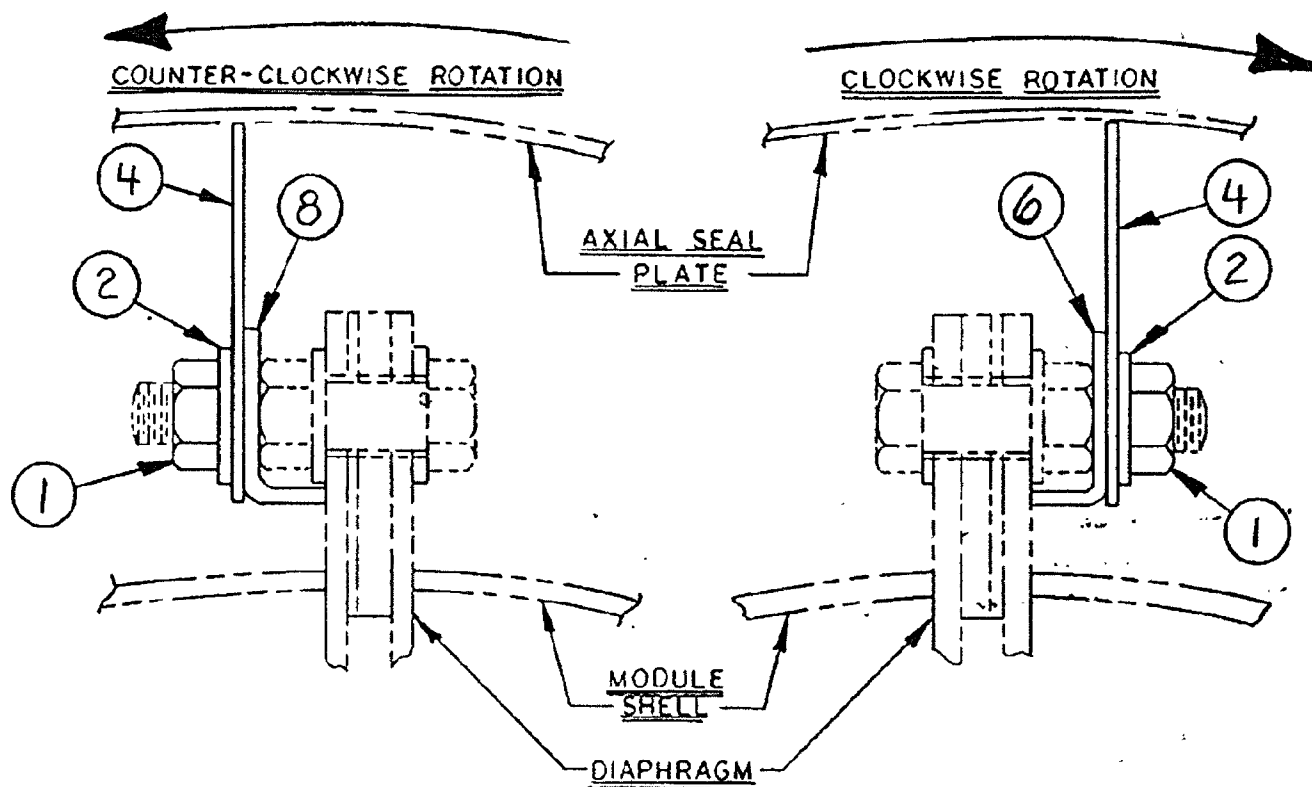
THIS DRAWING IS THE PROPERTY OF THE AIR PREHEATER COMPANY
SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART
FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OF
MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT
WRITTEN PERMISSION OF THE AIR PREHEATER COMPANY.

BILL OF MATERIAL						
REF. NO.	PART CODE NO.	DRAWING NO.	REQ'D.	MAT'L.	DESCRIPTION	LOFT
1	32050	P-12-25412	"C"	3205	3/4" FIN. HEX. NUT	SL
2	32140	P-12-25413	"C"	3214	3/4" WASHER	SL
3		D-E-78076	24		AXIAL SEAL LEAF (COLD END)	SL
4		D-F-78076	24		AXIAL SEAL LEAF (HOT END)	SL
THE FOLLOWING TO BE FOR CLOCKWISE ROTATION						
5		D-G-76118	24		FORMED HOLDING STRIP (COLD END)	SL
6		D-H-76117	24		FORMED HOLDING STRIP (HOT END)	SL
THE FOLLOWING TO BE FOR COUNTER-CLOCKWISE ROTATION						
7		D-G-76117	24		FORMED HOLDING STRIP (COLD END)	SL
8		D-H-76118	24		FORMED HOLDING STRIP (HOT END)	SL

NOTES TO ERECTOR:

ER-1 REFER TO SEAL INSTALLATION & SETTING DRAWING SPECIFIED IN GROUP 2106.

ER-2 NOTCH FORMED HOLDING STRIP TO FIT AT ASSEMBLY.



SECTION "A-A" (B-3)
AS VIEWED FROM HOT END

2 LAYER SIDE REMOVAL - DEF. SECTOR PL.

AND IT TO FOR IOUT	SUPERSEDED BY	Subject AIR PREHEATER	PROCESS EQUIPMENT		CE AIR PREHEATER WELLSVILLE, NEW YORK			
		Model/ Arrg't MOD.	AXIAL SEAL ASSEMBLY					
SUPERSEDES		Size, Type Series 32 1/2 - 34 VI.						
		Des. KAT						
		Ch. DV						
		Tr. 						
		Material 						
		Stk. No. 	CODES ER		DRAWING NUMBER			
		DATE 3-15-83	80100		GROUP 0504	SIZE C		
		SCALE NTS	(M)		NUMBER 78075	ISSUE 		
			WT. 		SHEET 	OF 		

GENERAL WELDING SPECIFICATIONS:

ALL WELDING SHALL BE PER AWS D1.1 AND/OR ASME SECTION 9 REQUIREMENTS. (REFERENCE AWS A5.1, AWS A5.5, ASME SECTION 9) THIS SPECIFICATION IS INTENDED FOR A36, A-588, WEATHERING

FILLER METAL-

THE FILLER METAL SHALL CONFORM TO THE REQUIREMENTS OF AWS A5.5/ASME SFA-5.5 GRADE E7018 LOW HYDROGEN ELECTRODES OR AWS A5.5/ASME SFA-5.5 GRADE E8018-W2 ELECTRODES BASED ON CONTRACT REQUIREMENTS. OTHER LOW HYDROGEN WELDING METALS SHALL REQUIRE WRITTEN APPROVAL FROM The Air Preheater Company, Inc.

FILLER METAL STORAGE-

ALL ELECTRODES SHALL BE PURCHASED IN HERMETICALLY SEALED CONTAINERS. ELECTRODES SHALL BE STORED IN THE HERMETICALLY SEALED CONTAINER, ELECTRODES SHALL BE STORED AT A MINIMUM OF AT LEAST 250 DEGREES FAHRENHEIT (F.). ELECTRODES SHALL BE DRY. ELECTRODES THAT HAVE BEEN WET SHALL NOT BE USED.

APPROVED ATMOSPHERIC TIME PERIODS-

AFTER HERMETICALLY SEALED CONTAINERS ARE OPENED OR AFTER STORAGE OVENS, THE ELECTRODE EXPOSURE TO THE ATMOSPHERE SHALL NOT EXCEED TWO (2) HOURS FOR E7018 ELECTRODES OR TWO (2) HOURS FOR E8018-W2 ELECTRODES. ELECTRODES EXPOSED TO THE ATMOSPHERE FOR PERIODS LESS THAN THOSE PERMITTED MAY BE USED AT 250 DEGREES F. MINIMUM; AFTER A MINIMUM HOLD PERIOD OF ONE HOUR AT 250 DEGREES F. THE ELECTRODES MAY BE REISSUED.

BAKING ELECTRODES-

ELECTRODES EXPOSED TO THE ATMOSPHERE FOR PERIODS GREATER THAN THOSE PERMITTED SHALL BE DISPOSED OF OR BAKED ACCORDING TO THE MORE STRINGENT OF THE FOLLOWING:

- 1. ALL ELECTRODES HAVING LOW HYDROGEN COVERINGS COATINGS SHALL BE BAKED FOR AT LEAST TWO (2) HOURS BETWEEN 500 DEGREES F. TO 700 DEGREES F.
 - 2. ALL ELECTRODES HAVING LOW HYDROGEN COVERINGS COATINGS SHALL BE BAKED FOR AT LEAST ONE (1) HOUR BETWEEN 700 DEGREES F. TO 1000 DEGREES F.
- ALL ELECTRODES SHALL BE PLACED IN A SUITABLE OVEN AT A MINIMUM OF 250 DEGREES F. OF THE FINAL BAKING TEMPERATURE FOR A MINIMUM OF ONE HOUR. AFTER BAKING, THE ELECTRODES SHALL BE REBAKED TO THE FINAL BAKING TEMPERATURE. ELECTRODES SHALL BE REBAKED TO THE FINAL BAKING TEMPERATURE. ELECTRODES THAT HAVE BEEN WET SHALL BE DISCARDED.

POSITION-

ALL WELDING SHALL BE PERFORMED IN THE FLAT, HORIZONTAL POSITION UNLESS OTHERWISE SPECIFIED IN INSTRUCTIONS ON DRAWINGS STATE OTHERWISE.

PREHEAT-

THE FOLLOWING SCHEDULE SHOWS RECOMMENDED PREHEAT TEMPERATURES	
BASE METAL THICKNESS	PREHEAT TEMPERATURE (MINIMUM)
0" TO 1.50" INCLUSIVE (0mm TO 38mm)	50 DEGREES F.
1.50" TO 2.50" INCLUSIVE (38mm TO 64mm)	150 DEGREES F.
OVER 2.50" (64mm)	225 DEGREES F.
THICKEST SECTION OF BASE METAL TO BE JOINED.	

PREPARATION OF BASE METAL-

THE SURFACES TO BE JOINED BY WELDING SHALL BE FREE OF OIL, GREASE, RUST, OR OTHER FOREIGN MATTER.

ELECTRICAL CHARACTERISTICS-

DIRECT CURRENT REVERSE POLARITY SHALL BE USED FOR WELDING.

PROCEDURE-

ALL WELDS SHALL BE MADE AS SPECIFIED ON DRAWINGS. ELECTRODE POSITIONING AND SHALL NOT EXCEED THE REQUIREMENTS OF AWS D1.1 LATEST EDITION. UNACCEPTABLE THEY ARE TO BE REMOVED BEFORE WELDING. BACKSLAG SHALL BE REMOVED PER PREHEAT SCHEDULE.

WORKMANSHIP AND VISUAL QUALITY-

EACH LAYER OF WELDING SHALL BE SMOOTH AND FREE OF CRACKS, UNFUSED METAL, COMPLETELY FUSED TO ADJACENT WELD BEADS OR BASE METAL. RIPPLES, IRREGULAR SURFACES, NON-UNIFORM BEAD PATTERNS, AND CONFORM TO THE REQUIREMENTS OF AWS D1.1 LATEST REVISION.

CLEANING-

ALL SLAG SHALL BE REMOVED FROM EACH WELD BEAD BEFORE THE NEXT LAYER OF WELD METAL. FINISHED WELDS MUST BE DE-SLAGGED AND WIRE BRUSHED FOR INSPECTION AND NON-DESTRUCTIVE EXAMINATION.

DEFECTS-

CRACKS, PINHOLES OR POOR TIE-INS SHALL BE REMOVED BEFORE THE NEXT SUBSEQUENT LAYERS OF WELD METAL.

QUALIFICATIONS-

WELDING PROCEDURES AND WELDERS MUST BE QUALIFIED IN ACCORDANCE WITH ASME BOILER AND PRESSURE VESSEL CODE OR AWS D1.1.

U				
T				
S				
R				
Q				
P	10/09/01	JRC	AGM	MODIFIED INSPECTION NOTE #1
O	06/21/00	KMF	ACS	ADDED CLARIFICATION FOR SPECIFIC NOTES
N	06/10/99	GP	KMF	REDRAWN FROM "D" SIZE & MODIFIED NOTES
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				

IN IX LATEST REVISION PER CONTRACT
N II PART C SFA-5.1 AND SFA-5.5.)
CARBON STEEL (LACR) AND LIKE MATERIALS.

IF AWS A5.1/ASME SFA-5.1 GRADE E7018
E8018-W2 LOW HYDROGEN ELECTRODES
LDING PROCESSES MAY BE USED WITH

LED CONTAINERS. IMMEDIATELY AFTER OPENING
ORED IN OVENS HELD AT A TEMPERATURE
L BE REBAKED NO MORE THAN ONCE.

FTER ELECTRODES ARE REMOVED FROM BAKING OR
- SHALL NOT EXCEED FOUR (4) HOURS FOR
ODES. ELECTRODES EXPOSED TO THE
RETURNED TO A HOLDING OVEN MAINTAINED
F FOUR (4) HOURS AT 250 DEGREES F. MINIMUM

HEATER THAN THOSE PERMITTED SHALL BE
THE MANUFACTURER'S INSTRUCTIONS OR THE

FORMING TO AWS A5.1/ASME SFA-5.1 SHALL BE
REES F. AND 800 DEGREES F.

FORMING TO AWS A5.5/ASME SFA-5.5 SHALL BE
REES F AND 800 DEGREES F.

TEMPERATURE NOT EXCEEDING ONE HALF (1/2)
F (1/2) HOUR PRIOR TO INCREASING THE OVEN
3 TIME SHALL START AFTER THE OVEN REACHES
ED NO MORE THAN ONCE. ELECTRODES THAT

L OR VERTICAL UP POSITION UNLESS

PECIFICATIONS:
HEAT RANGE
1° F. (10° C) MINIMUM
2° F. (66° C) MINIMUM
3° F. (107° C)MINIMUM

IF DIRT, OIL, GREASE AND EXCESSIVE RUST SCALE

LDING.

ELECTRODE WEAVING SHALL BE KEPT TO A MINIMUM
T REVISION. TACKWELDS MAY BE INCORPORATED
BE FREE OF DEFECTS. IF TACKWELDS ARE FOUND
SE METAL MUST BE PREHEATED FOR TACKWELDING

RACKS, PINHOLES, UNDERCUTS AND SHALL BE
COVER PASSES SHALL BE FREE OF COARSE
HIGH CROWNS, DEEP RIDGES, UNDERCUTS, ETC.
SION

RE DEPOSITING THE NEXT SUCCESSIVE LAYER OF
BRUSHED TO PERMIT THOROUGH VISUAL

CHIPPING OR GRINDING PRIOR TO DEPOSITING

ACCORDANCE WITH SECTION IX OF THE

THE FOLLOWING DETAIL
NOTES 1, 4
NOTE 2 IS
NOTES 3, 9

INSPECTION AND TEST-

- 1. ALL FINISHED WELDS COMPLIANCE WITH THE
- 2. ALL FINISHED WELDS ACCORDANCE WITH AF DIVISION 1 LATEST ED DIMENSIONALLY CHECK SPECIFIED ON THE DF
- 3. ALL FULL PENETRATIC APPENDIX 12, ASME (
- 4. LIQUID PENETRANT, M PERFORMED UNTIL TH
- 5. THE AIR PREHEATER I FULL RIGHTS OF ACCI WITH THESE REQUIREM
- 6. NON-DESTRUCTIVE TE OPERATOR DEFECTS A
- 7. THE ROOT PASS OF E BE CONTINUOUSLY MA
- 8. THE INTENT OF THIS WELD METAL IN ACCO, ASME SECTION IX. TI QUALIFIED SUPERVISIO THE REFERENCED WEL
- 9. RADIOGRAPHIC EXAMIN TO ULTRASONIC EXAMI SECTION VIII, DIVISION
- 10. ULTRASONIC EXAMINAT THE DIAPHRAGM IS JC 12" (305mm) LONG BETWEEN THE INITIAL REJECTABLE APPLICATI EXAMINED. REJECTABL. METHODS PER NOTE 7
- 11. SEAL WELDS ARE TO THE CASE OF SEAL W 3/16" (4mm).

GROUND
RO
AND/OR
DAMAGE

MATERIA
SOI
WEATHE
FOR SF
ORDER
CONTAC
SERVICE
REPRES

ASSEMBLY TOLERANCE UNLESS NOTED ON DRAWING		FIELD WELD REQUIREMEN UNLESS NOTED ON DRAW		
0-24 (0-610mm) 24-96(610-2438mm) OVER 96(2438mm) ANGLES STD	±0.13(3mm)	CONVERSIONS		FILLER METAL - E7018 UNLESS OTHER SPECIFIED ALL WELDS TO CONFORMANCE AWS D1.1 STR WELDING CODE EQUIVALENT
	±0.19(5mm)	INCH	MM	
	±0.25(6mm)	1/8	3	
		3/16	4	
		1/4	6	
		5/16	8	
		3/8	10	
		1/2	12	
	±0.5°			

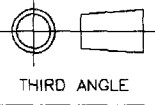
S THE USE OF NOTES #1 THROUGH #11 BELOW:
, 5, 6, 7, 8, & 11 ARE GENERAL NOTES FOR ALL JOBS.
REQUIRED ONLY IF SPECIFIED ON THE ERECTION DRAWING.
, & 10 ARE SPECIFICALLY FOR FULL PENETRATION WELDS.

WILL BE 100% VISUALLY EXAMINED AND DOCUMENTED TO ENSURE
PRECEDING REQUIREMENTS.
WILL BE MAGNETIC PARTICLE OR LIQUID PENETRANT EXAMINED IN
PENDIX 6 OR APPENDIX 8 RESPECTIVELY ASME CODE, SECTION VIII,
ITION TO ENSURE THE SURFACES ARE FREE FROM DEFECTS AND
ED TO ENSURE THEY MEET THE MINIMUM SIZE REQUIREMENT
AWING.
N WELDS WILL BE ULTRASONIC EXAMINED IN ACCORDANCE WITH
CODE, SECTION VIII, DIVISION 1 LATEST EDITION.
AGNETIC PARTICLE AND ULTRASONIC EXAMINATIONS MUST NOT BE
E WELD HAS COOLED TO AMBIENT TEMPERATURE.
COMPANY, INC. AND/OR AUTHORIZED REPRESENTATIVES SHALL HAVE
ESS TO INSPECT AND/OR TEST WELDS AND DETERMINE COMPLIANCE
MENTS.
STING SHALL BE PROGRESSIVE TO ENSURE THAT PROCESS OR
RE NOT PERPETUATED.
EACH WELD SHALL BE VISUALLY INSPECTED. PREHEAT SHALL
INTAINED THROUGHOUT THE WELDING CYCLE.
WELDING PROCEDURE IS TO DEPOSIT HIGH QUALITY, LOW HYDROGEN
RDANCE WITH THE REQUIREMENTS OF AWS D1.1 OR
HE WELDING IS TO BE CARRIED OUT UNDER THE DIRECTION OF
N AND Q.C. PERSONNEL WHO FULLY UNDERSTAND THE INTENT OF
DING CODES AND WELDING PROCEDURES.
ATION OF FULL PENETRATION WELDS IS AN ACCEPTABLE ALTERNATIVE
INATION AND IS TO BE DONE IN ACCORDANCE WITH ASME CODE,
1 LATEST EDITION ACCEPTANCE CRITERIA PER PARAGRAPH UW.51.
ION SHALL BE PERFORMED AT BOTH HOT AND COLD ENDS WHERE
INED TO THE STUB DIAPHRAGM. A SPOT ULTRASONIC EXAMINATION
SHALL BE DONE TO THE DIAPHRAGM TO STUB DIAPHRAGM JOINT
END SECTIONS WHEN FULL PENETRATION WELDS ARE SPECIFIED. IF
IONS ARE FOUND, THE ENTIRE LENGTH OF THE WELD WILL BE
E AREAS WILL BE REPAIRED AND RE-EXAMINED BY ULTRASONIC
#9 ABOVE.
BE A MINIMUM OF 1/8" (3mm) UNLESS OTHERWISE SPECIFIED. IN
ELDS REQUIRED ON A DYNAMIC COMPONENT THE MINIMUM SIZE IS

DING NOTE
TOR TO BE GROUNDED ANY TIME WELDING
R AIR ARCING IS TAKING PLACE TO PREVENT
T TO BEARINGS AND DRIVES.

AL NOTE
ME AIR PREHEATER PARTS ARE PRODUCED FROM
RING STEEL (LACR) FOR CORROSION RESISTANCE.
PECIFIC LOCATIONS OF WEATHERING STEEL ON AN
PLEASE SEE THE SPECIFIC ASSEMBLY DRAWING OR
T YOUR REGIONAL AIR PREHEATER SALES OFFICE,
E REPRESENTATIVE OR YOUR INSIDE SALES
ENTATIVE.

THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY
AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE
OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS
OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON
WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

TS NG	SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHER- WISE SPECIFIED		ALSTOM ALSTOM Power, Inc. Air Preheater Company Wellsville, New York				
		SUBJECT AIR PREHEATER		GENERAL WELDING SPECIFICATIONS				
		API NO.						
		SIZE		CODE ER	GROUP 0100	SIZE C	DWG NO. 65357	REV P
		DR RF	CK ---					
		APPR. BY						
BE IN WITH CTURAL OR	SUPERSEDES	DATE 1-30-75		SCALE NTS		WT	SHEET	OF

DECIMAL	FRACTIONAL EQUIVALENT
0.03	1/32
0.06	1/16
0.09	3/32
0.13	1/8
0.16	5/32
0.19	3/16
0.22	7/32
0.25	1/4
0.28	9/32
0.31	5/16
0.34	11/32
0.38	3/8
0.41	13/32
0.44	7/16
0.47	15/32
0.50	1/2

DECIMAL	FRACTIONAL EQUIVALENT
0.53	17/32
0.56	9/16
0.59	19/32
0.63	5/8
0.66	21/32
0.69	11/16
0.72	23/32
0.75	3/4
0.78	25/32
0.81	13/16
0.84	27/32
0.88	7/8
0.91	29/32
0.94	15/16
0.97	31/32
1.00	1

THIS DRAWING IS THE PROPERTY OF ABB AIR PREHEATER, INC. AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF THE ABB AIR PREHEATER, INC.

MARK	DATE	DR.	CK.
H			
G			
F			
E			
D			
C			
B			
A			


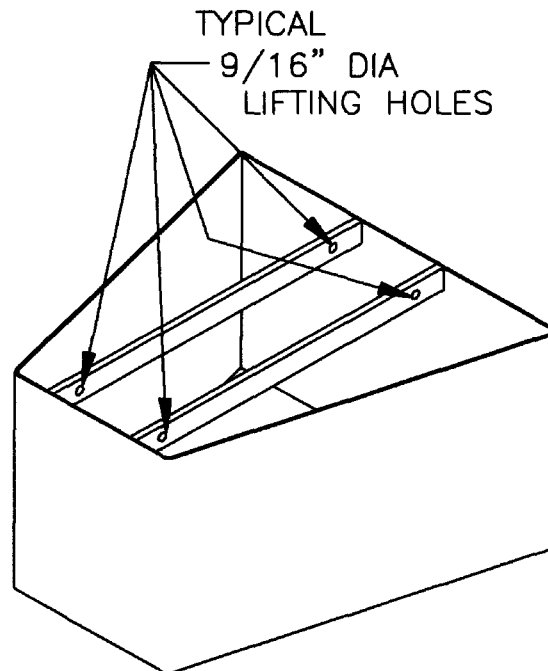
SUPERSEDED BY		ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
SUBJECT		AIR PREHEATER	
API NO.		SIZE V-VI-H	
DR		VB	CK
APPR. BY		DATE 06-30-99	

		ABB AIR PREHEATER, INC.	
		WELLSVILLE, NEW YORK	
DECIMAL TO FRACTIONAL REFERENCE TABLE			
CODE	GROUP	SIZE	DWG NO.
ER	2200	E	98856
SCALE NTS			WT
SHEET			OF

W:\STD\BASKETS\LIFTING



TYPICAL LIFTING ARR'G'T.

NOTES TO ERECTOR:


BASKETS TO BE LIFTED WITH 4 POINT LIFT. LIFTING HOLES ARE PROVIDED IN HOLDING BARS FOR CLEVISES OR SHACKLES. SIZE CLEVISES OR SHACKLES FOR A MAXIMUM 2400 LB. BASKET WEIGHT.

LIFTING EQUIPMENT FURNISHED BY OTHERS.

TO BE USED ON 90 DESIGN AND FULL WRAPPER BASKETS ONLY.

THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

H			
G			
F			
E			
D			
C			
B			
A			
MARK	DATE	DR.	CK.
ALTERATIONS			

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		 THIRD ANGLE		ALSTOM					ALSTOM Power, Inc. Air Preheater Company Wellsville, New York						
	SUBJECT							LIFTING ARRANGEMENT								
	AIR PREHEATER															
	API NO.															
	SUPERSEDES	SIZE V-VI							CODE					GROUP	SIZE	DWG NO.
DR BLM CK CU							ER		0200		E		99502			
APPR. BY CU									0202							
DATE 06-23-00							SCALE NTS			WT		SHEET		OF		

IP7_033804

03062713

D

C

B

A

PREHEATER
CENTERLINE

GAS SIDE

27100

24.94

18.19

196.25

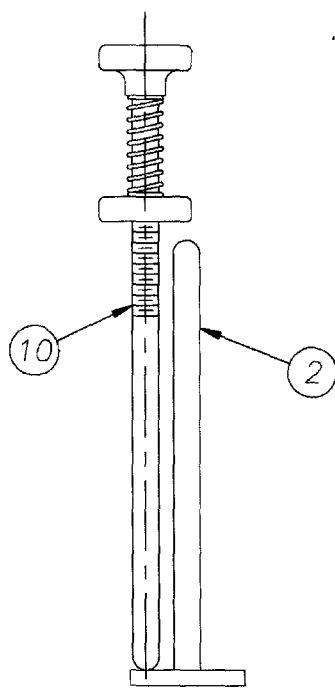
"A"

"A"

CENTERLINE OF PREHEATER
AND HOT END CENTER SECTION

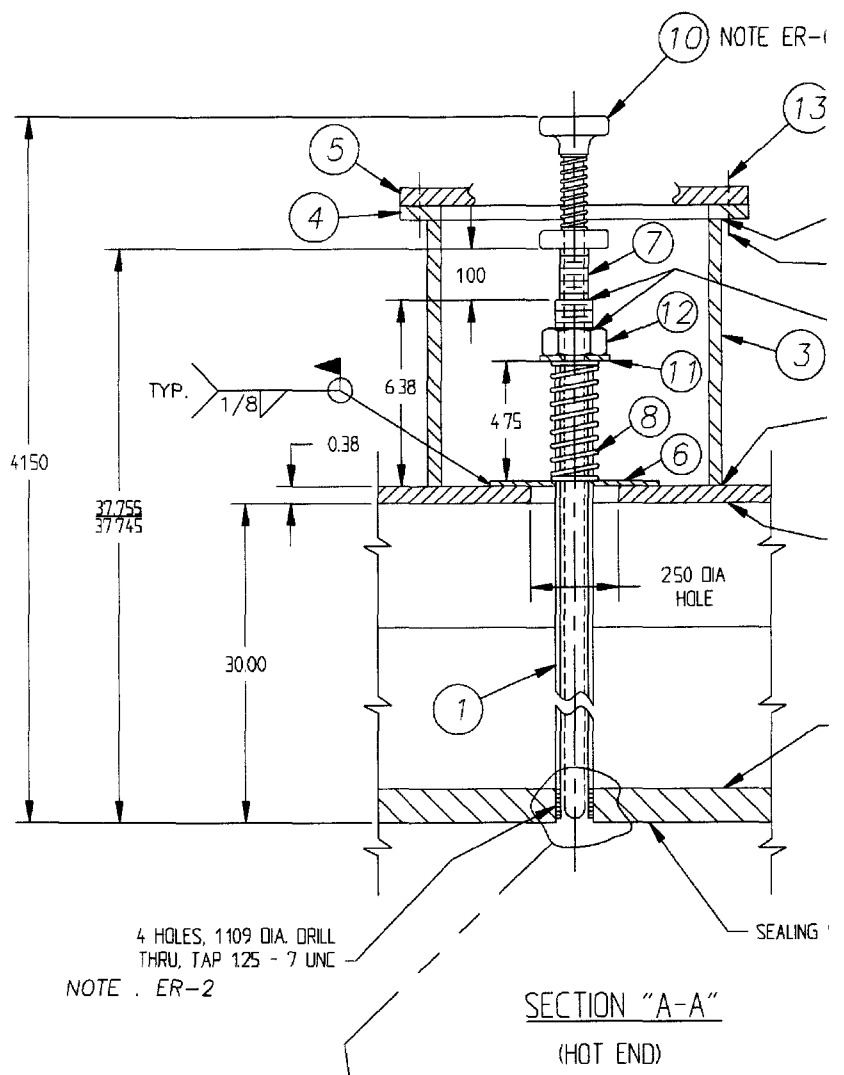
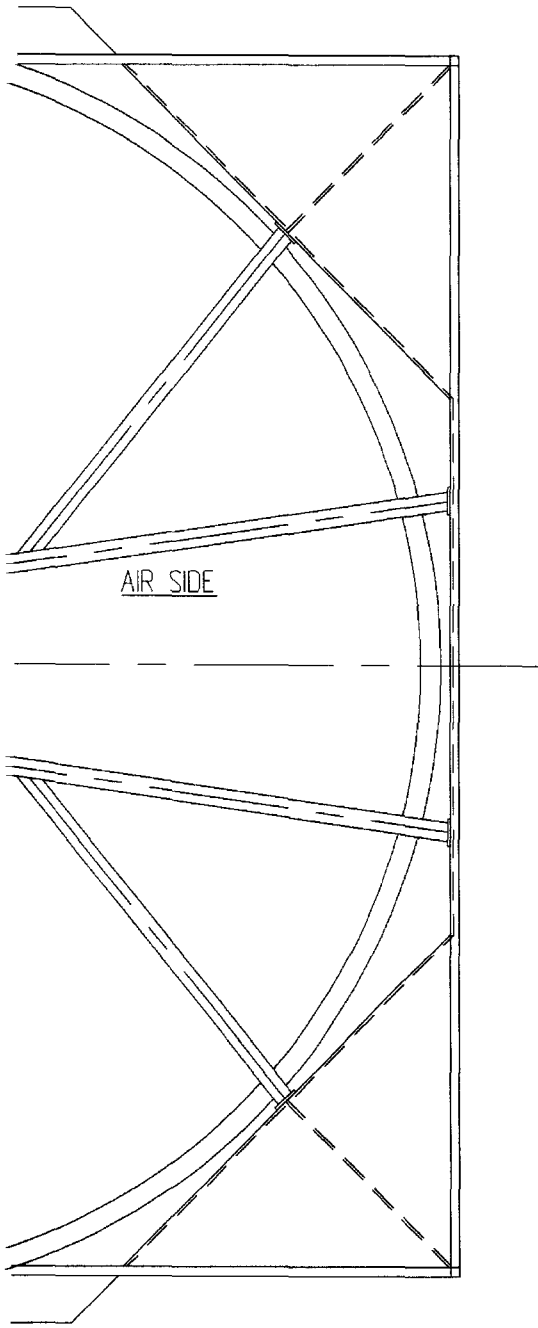
4 HOLES PER CENTER
SECTION 250 DIA

TOP PLAN VIEW



VIEW SHOWING USE OF
GAUGE ROD SETTING BAR ASS'Y

H				
G				
F				
E				
D				
C				
B				
A				
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				



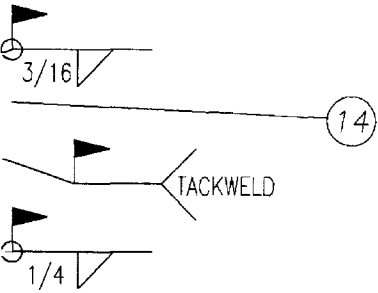
[4098 / 03062713]

BILL OF MATERIAL					
REF.	DRAWING NO.	QTY.	MAT'L.	DESCRIPTION	S.L.
1	D-85512	4		H.E. SEAL GAUGE TUBE ASS'Y (ASS'Y #11)	SL
2	D-49622	1		H.E. GAUGE ROD SETTING BAR (ASS'Y #5)	SL
3	6500160040152	4	6501	6 SCH #40 PIPE X 9 50 LG	SL
4	C-2-85510	4	4006	0.38 X 7.25 X 7.25	SL
5	C-3-85510	4	4006	0.25 X 7.25 X 7.25	SL
6	P-1-30534	4	3215	GAUGE WASHER	SL
7	E-26907	4		SEAL GAUGE BUSHING	SL
8	P-2895	4	9904	BLISS JIG SPRING #DS-240 6.00 LG.	SL
9	D-85511	4		BUSHING CAP	SL
10	D-49623	1		H.E. GAUGE ROD ASS'Y (ASS'Y #5)	SL
11	P-20-25413	4	3214	1.25 WASHER	SL
12	P-20-25412	4	3205	1.25 FIN. HEX. NUT	SL
13	P-10-3079	16	3201	0.63 X 1.25 HEX. HD. CAPSCREW	SL
14	P-10-25412	16	3205	0.63 FIN. HEX. NUT	SL

NOTES TO ERECTOR

- ER-1 DRILL FOUR HOLES THRU THE HOT CENTER SECTIONS
- ER-2 DRILL AND TAP HOLES INTO SECTOR PLATES AS SHOWN IN SECTION "A-A"
- ER-3 CENTER REF #3 ON #4 & WELD AS SHOWN, THEN CENTER THE ASSEMBLY OF REF #3 & #4 OVER HOLE IN CENTER SECTION AND WELD TO TUB PLATE AS SHOWN IN SECTION "A-A"
- ER-4 ASSEMBLY REF #1, #7, #6, #8, #11, #12 AS SHOWN IN SECTIONS "A-A", MAKING SURE REF #1 IS WITHIN 0.13" OF THE SEALING SURFACE
- ER-5 AFTER FINAL SETTING OF SECTOR PLATE TIGHTEN REF #12 AND TACKWELD.
- ER-6 INSERT REF. #10 INTO REF #7, ADJUST 1/4 TURN AT EACH REVOLUTION OF ROTOR UNTIL ROUNDED END JUST TOUCHES THE RADIAL SEALS
- ER-7 REMOVE REF #10 USE REF #9 TO CAP THE TUBE AND INSTALL THE COVER REF #5 USING REF. #13 & #14.
- ER-8 CHECK SEAL CLEARANCE USING REF. #2 RESPECTIVELY TO DETERMINE THE ACTUAL SEAL SETTINGS

& 7

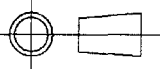


CENTER SECTION
TUB PLATE

SECTOR PLATE

URFACE

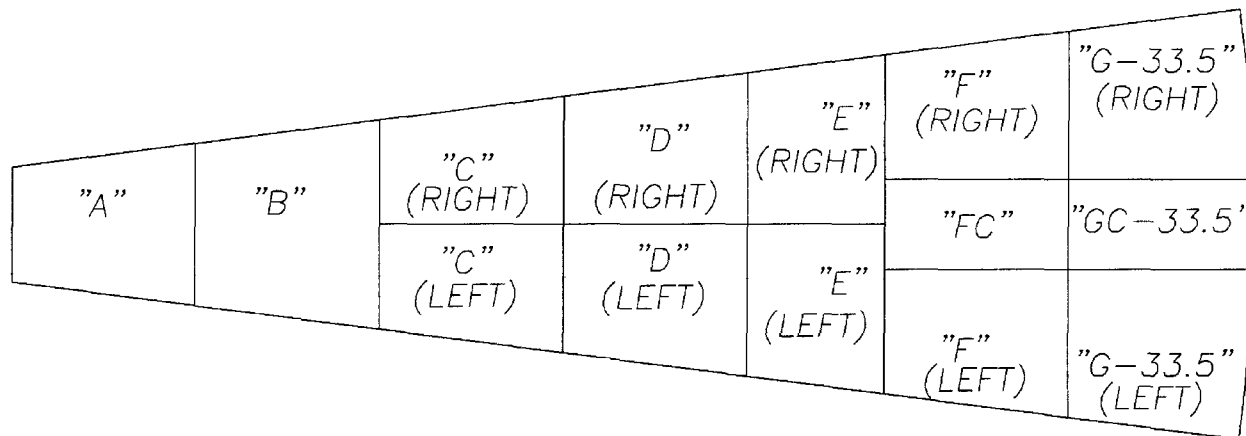
THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY
AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE
OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS
OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON
WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHER- WISE SPECIFIED	 THIRD ANGLE	ALSTOM ALSTOM Power Inc. Air Preheater Company Wellsville, New York					
	SUBJECT AIR PREHEATER		HOT END SEAL CLEARANCE GAUGE ASS'Y					
SUPERSEDES	API NO.							
	SIZE 33.5 VI MOD							
	DR WDS	CK DV	CODE	GROUP	SIZE	DWG NO.	REV	
	APPR. BY		ER	0401	C	10041246		
	DATE 10-25-04		SCALE NTS		WT		SHEET OF	

L\STD\BASKET\ARRGT\33.5

NOTE TO ERECTOR:

ER-1 TO BE USED WITH BASKET SEALS ONLY

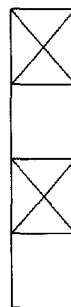


TOP PLAN VIEW

THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

H			
G			
F			
E			
D			
C			
B			
A			
MARK	DATE	DR.	CK.
ALTERATIONS			

LAYER



HE
HI
CE
CI

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	 THIRD ANGLE		ALSTOM ALSTOM Power Inc. Air Preheater Company Wellsville, New York			
	SUBJECT AIR PREHEATER		BASKET ARRANGEMENT				
SUPERSEDES	API NO.						
	SIZE 33.5 V/VI						
	DR CU	CK CU	CODE	GROUP	SIZE	DWG NO.	REV
	APPR. BY		ER	0200	A	80030674	
DATE 12/11/03		SCALE NTS		WT		SHEET OF	

IP7_033808

03062713

D

3 SIDES DO NOT WELD
ACROSS SPLIT IN T-BAR
NOTE ER-4

1/4

WIDE
SIDE
OF FLG.

WIDE
SIDE
OF FLG.

T-BARS M
UNEQUAL
TO MILL T
INSTALL T
SEGMENTS
WIDE SIDE
FLANGES !
SAME DIR
SO THAT
LINE UP.

VIEW "C-C" (B-7)

C

B

NOTE ER-4

1/8

NOTE ER-4

1/8

G

0.31

"C"

PL

0.50

2.50

5.00

0.50

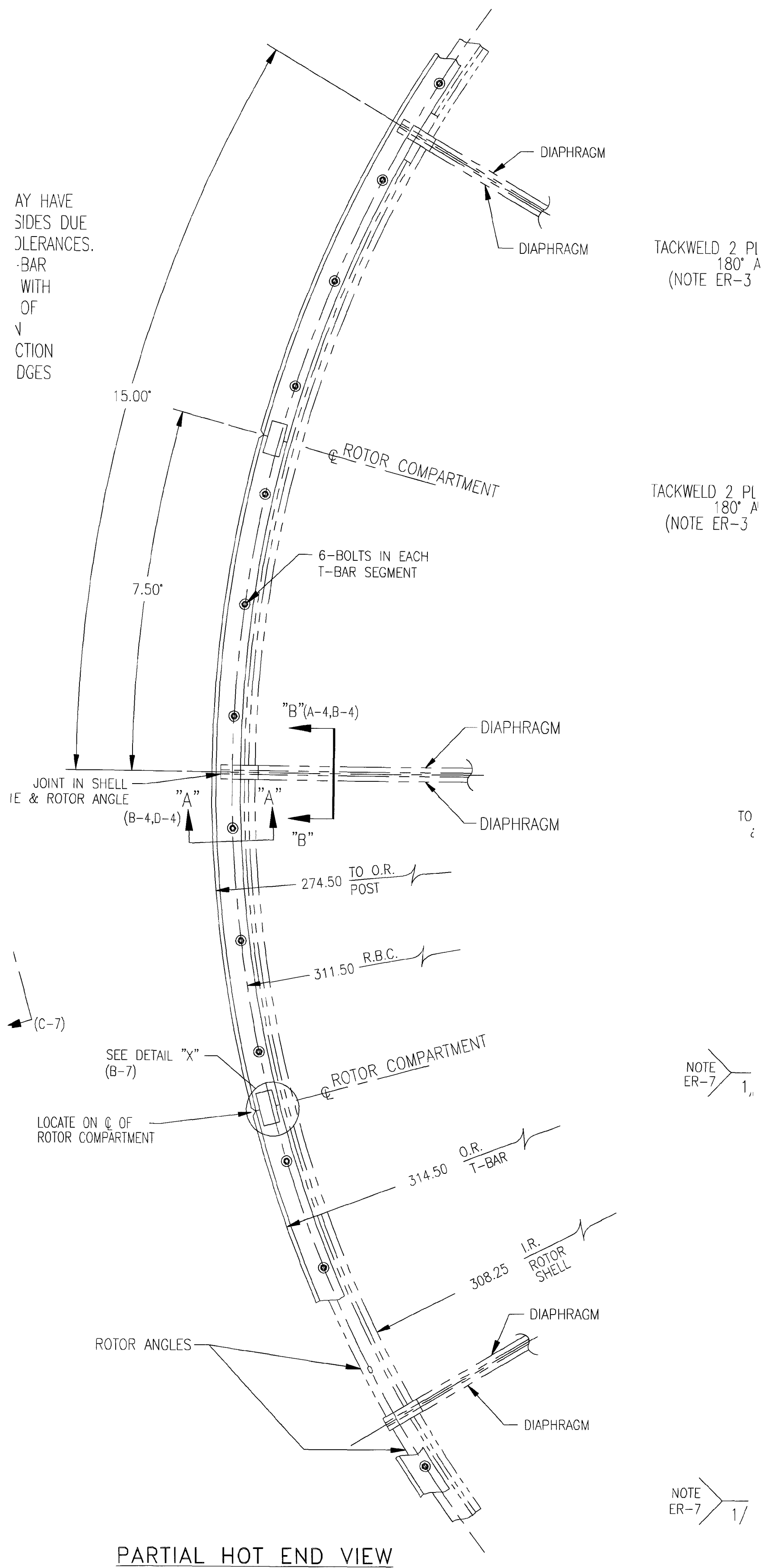
"C"

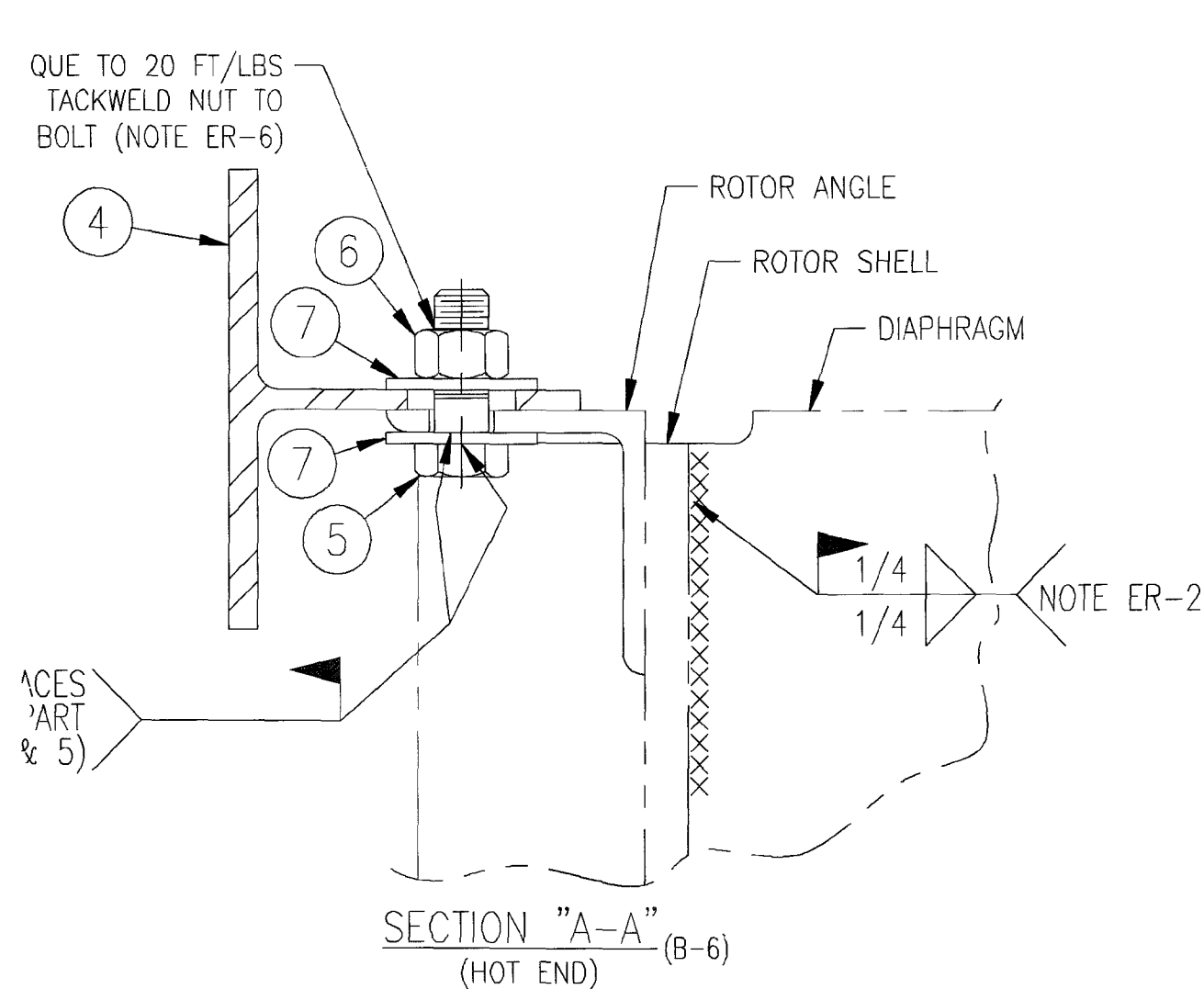
DETAIL "X" (B-6)

A

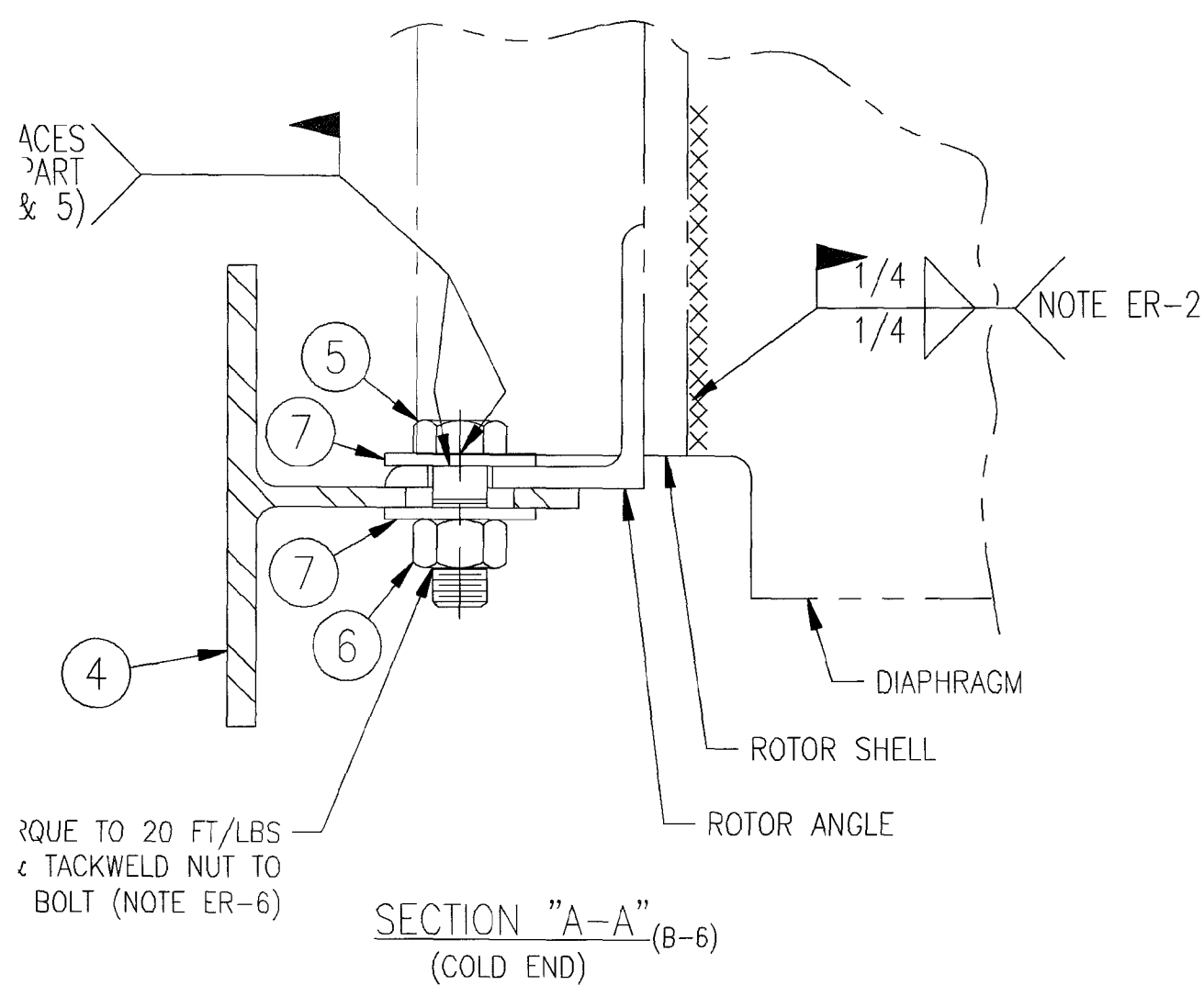
H				
G				
F				
E				
D				
C				
B				
A				
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				

[4098/04064E





REF.	DRAWING NO
1	E-77351
2	E-77345
3	E-95943
4	B-77352
5	P-14-31500
6	P-10-1420
7	P-6-1289



NOTES TO ERECTOR:

ER-1 REMOVE EXIST.

ER-2 INSPECT THE
IF FRACTURES
END OF THE

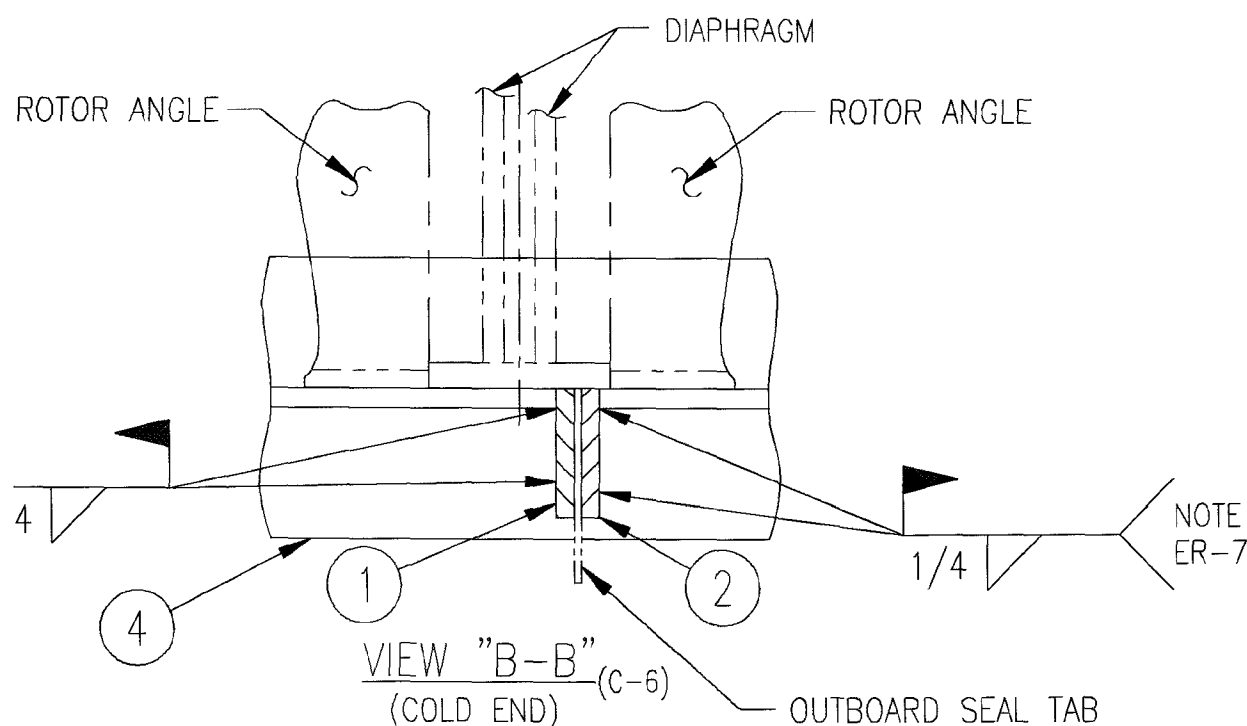
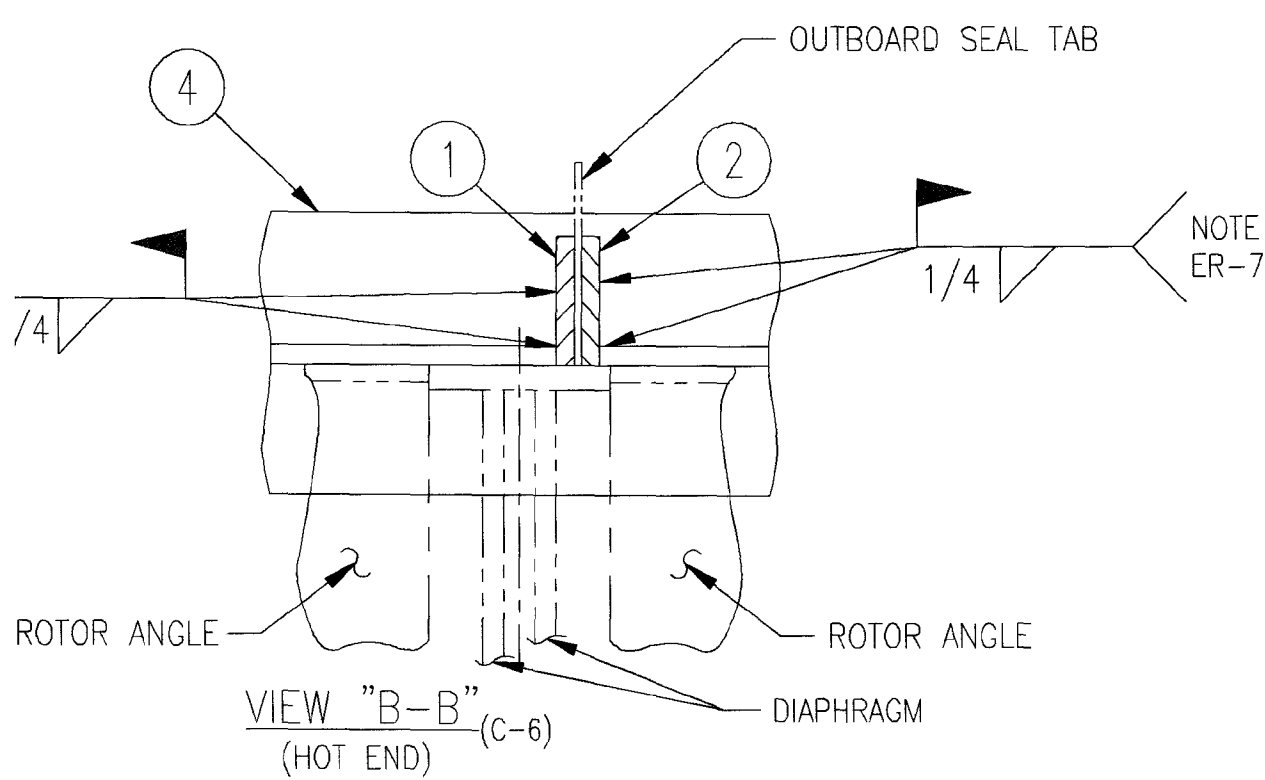
ER-3 INSTALL THE
THE ROTOR C
0.13". ALL I
SHOWN IN SE

ER-4 WELD T-BARS
VIEW "C-C".

ER-5 TACKWELD BO
AND THEN TA

ER-6 BACK OFF NL
BOLT TO NUT
T-BAR).

ER-7 WELD THE T-
THE T-BAR C
ON LEADING



SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHER- WISE SPECIFIED	⌀
	SUBJECT AIR PREH!	
SUPERSEDES	API NO.	
	SIZE 33.5 VI	
	DR GP	ck
	APPR. BY	
	DATE 12/16/1	

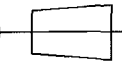
BILL OF MATERIAL

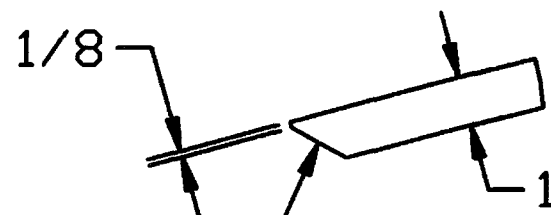
	QTY.	MAT'L.	DESCRIPTION	S.L.
	48		T-BAR TAB	S.L.
	48		T-BAR TAB	S.L.
	48		SPLICE BAR	S.L.
	48		T-BAR (ASS'Y. #3)	S.L.
	288	3201	0.63 X 1.75 HEX. HEAD CAPSCREW	S.L.
	288	3205	0.63 FIN. HEX. NUT	S.L.
	576	3221	0.63 WASHER	S.L.

NG T-BARS AND T-BAR TABS.
WELD BETWEEN THE ROTOR SHELL AND THE DIAPHRAGM FOR FRACTURES.
ARE FOUND, REMOVE THE EXISTING WELD TWO INCHES BEYOND THE
RACTURE AND REWELD AS SHOWN IN SECTION "A-A".
-BARS (REF. #4) WITH THE ENDS LOCATED ON THE CENTER-LINES OF
MPARTMENTS AND TO THE RADIUS SHOWN WITH A TOTAL RUN-OUT OF
HE BOLTS, NUTS, AND WASHERS ARE TO BE INSTALLED EXACTLY AS
CTION "A-A". TIGHTEN ALL BOLTS PRIOR TO WELDING.
(REF. #4) AND SPLICE BAR (REF. #3) AS SHOWN IN DETAIL "X" AND
T HEADS (REF. #5) TO WASHERS (REF. #7) ACROSS FLATS 180° APART,
K WELD THE WASHERS TO THE ANGLES 180° APART FOR 0.75".
IS (REF. #6) AND THEN TORQUE TO 20 FT./LBS. THEN TACK WELD
(DO NOT TACK WELD THE NUT TO THE WASHER OR WASHER TO THE

BAR TABS (REF. #1 & #2) AS SHOWN IN SECTION "B-B". WELD TO
NLY. INSTALL REF. #1 ON TRAILING SIDE OF RADIAL SEALS AND REF. #2
SIDE.

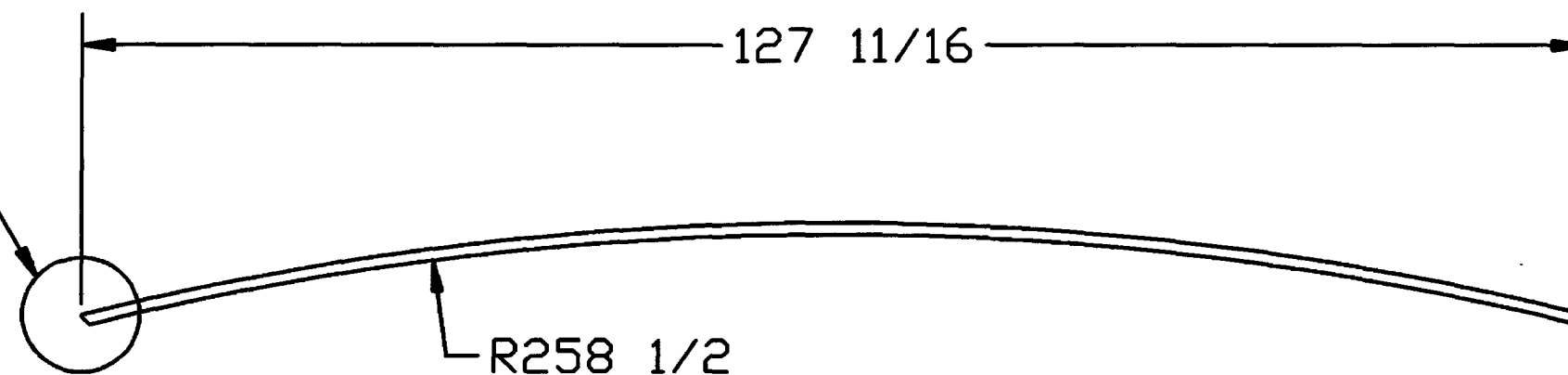
THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY
AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE
OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS
OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON
WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

	ALSTOM ALSTOM Power Inc. Air Preheater Company Wellsville, New York				
ATER	HOT & COLD END FLOATING T-BAR INSTALLATION				
MOD)					
DV	CODE	GROUP	SIZE	DWG NO.	REV
	ER	0103	D	10041587	
4	SCALE NTS		WT		SHEET OF



DETAIL "Z"
(1 END ONLY)

DETAIL "Z"




DESCRIPTION: 1 X 8 X 128-3/4 ROLL TO 258-1/2 I.R.
MATERIAL: 40006

THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY
AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE
OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS
OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREIN
WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

H				
G				
F				
E				
D				
C				
B				
A	10-31-02	JRL	RAD	CHANGED DIMENSIONS
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				

LJUNG/CONT/4399/NEW/0402

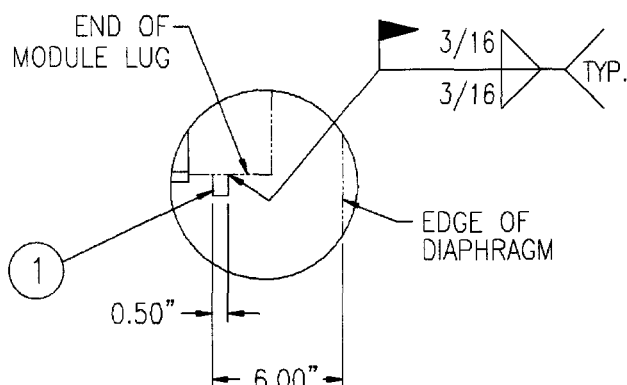
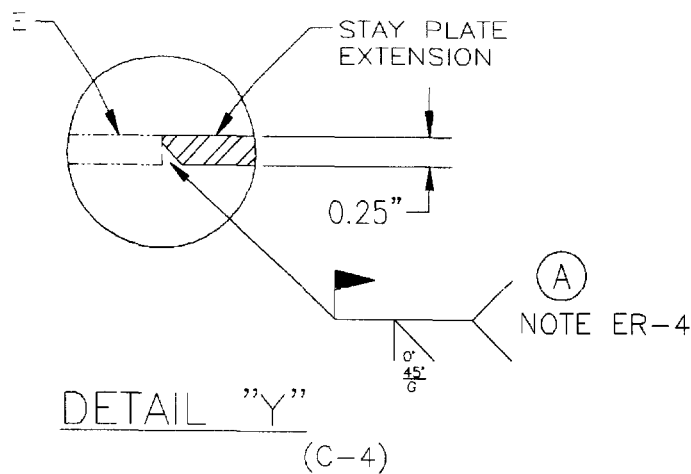
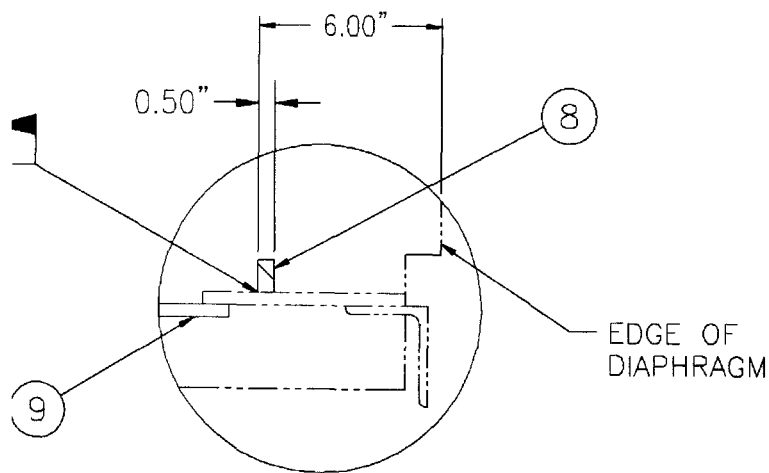
SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHER- WISE SPECIFIED	 THIRD ANGLE	ALSTOM ALSTOM Power Inc. Air Preheater Company Wellsville, New York				
	SUBJECT AIR PREHEATER		TENSION RING				
	API NO.						
	SIZE 31 VI						
	DR JRL	CK RAD	CODE	GROUP	SIZE	DWG NO.	REV
SUPERSEDES	APPR. BY			0400	B	10021477	A
	DATE 10-7-02		SCALE NTS		WT	SHEET	OF

BILL OF MATERIAL

REF.	Drawing #	QTY.	MAT'L	DESCRIPTION	S.L.
1	A-10031481	24		INBOARD BASKET SUPPORT BAR	SL
2	C-105534	24		"A" STAY PLATE EXTENSION ASSEMBLY ASS'Y #7	SL
3	C-105534	24		"B" STAY PLATE EXTENSION ASSEMBLY ASS'Y #8	SL
4	C-105534	24		"C" STAY PLATE EXTENSION ASSEMBLY ASS'Y #9	SL
5	C-105534	24		"D" STAY PLATE EXTENSION ASSEMBLY ASS'Y #10	SL
6	C-105534	24		"E" STAY PLATE EXTENSION ASSEMBLY ASS'Y #11	SL
7	C-105534	24		"F" STAY PLATE EXTENSION ASSEMBLY ASS'Y #12	SL
8	D-11-66473	24		BASKET SUPPORT AT SHELL	SL
9	B-3-78067	24		COVER ASSEMBLY	SL
10	P-10-30765	192	3222	0.63 X 1.25 AW WELD STUD	SL
11	P-10-25412	192	3205	0.63 HEX NUT	SL
12	P-10-25413	192	3214	0.63 WASHER	SL

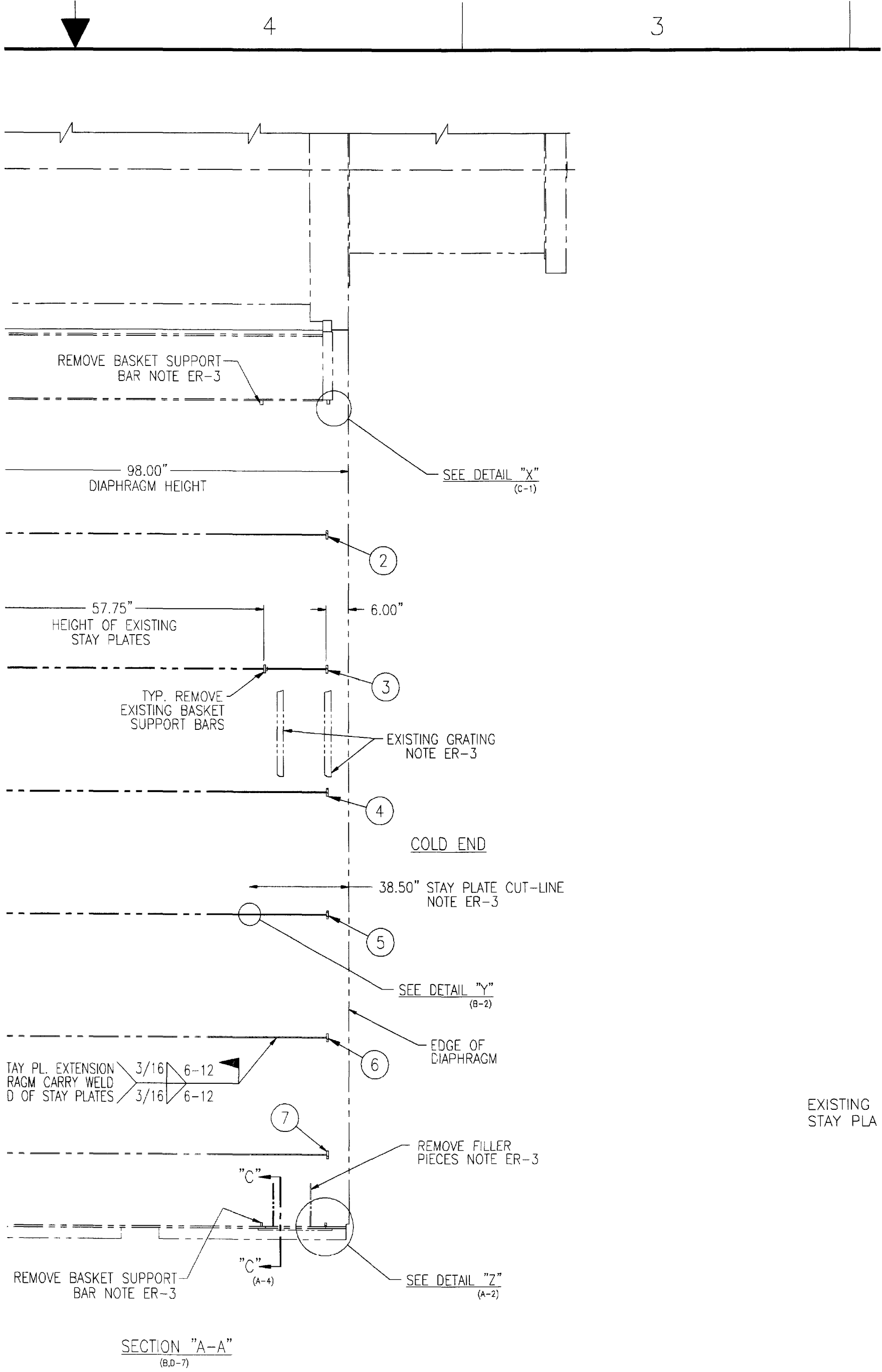
NOTES TO ERECTOR:

- ER-1 REMOVE ALL ELEMENT BASKETS FROM ALL LAYERS BEFORE PERFORMING ROTOR MODIFICATION WORK. ROTOR TO BE PROPERLY GROUNDED BEFORE WELDING TO PREVENT DAMAGE TO BEARINGS AND DRIVES.
- ER-2 ALL ROTOR MODIFICATION WORK SHOULD BE COMPLETED SO THAT EVERY OTHER COMPARTMENT IS WORKED ON ONE AT A TIME, AFTER COMPLETION OF EVERY OTHER COMPARTMENT THE BALANCE OF THE ROTOR CAN BE FIT TACK AND WELDED.
- ER-3 REMOVE THE EXISTING BASKET SUPPORT BARS, FILLER PIECES, GRATING, AND DISCARD. TRIM STAY PLATES TO THE CUT LINE DIMENSION SHOWN IN SECTION "A-A".
- ER-4 INSTALL THE STAY PLATE EXTENSIONS AS SHOWN. (EXTRA CARE SHOULD BE TAKEN TO MAKE SURE THAT THE STAY PLATE EXTENSIONS LINE UP WITH THE CORRESPONDING EXISTING STAY PLATES). MAINTAIN BASKET SUPPORT ELEVATION FLAT WITHIN 1/8".
- ER-5 INSTALL THE INBOARD AND OUTBOARD BASKET SUPPORT BARS REF. #1 & #8 AS SHOWN AND WELD INTO PLACE.
- ER-6 CENTER REF. #9 OVER SHELL OPENING AND SEAL WELD AS SHOWN ON THE COVER I.R. (REFER TO SECTION "C-C"). NEW FASTENERS ARE BEING SUPPLIED FOR REF. #9 TO SECURE COVER FOR WELDING IF DESIRED.
- ER-7 USE E-8100 WEATHERING WIRE FOR ALL WELDS.

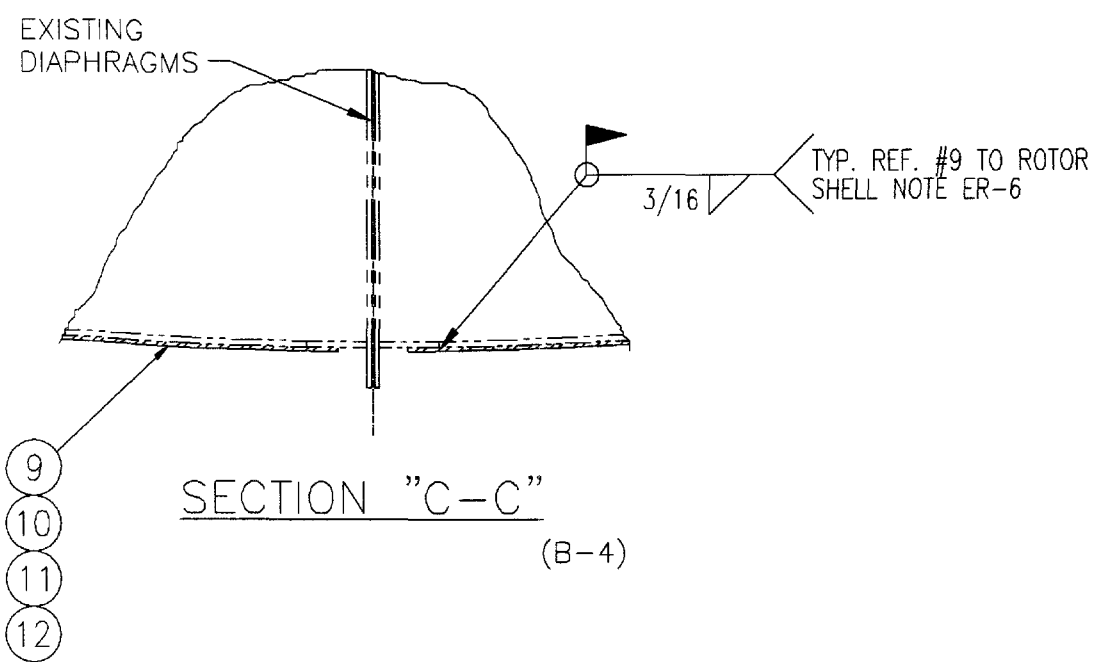
DETAIL "X"
(D-4)DETAIL "Y"
(C-4)DETAIL "Z"
(B-4)

THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY

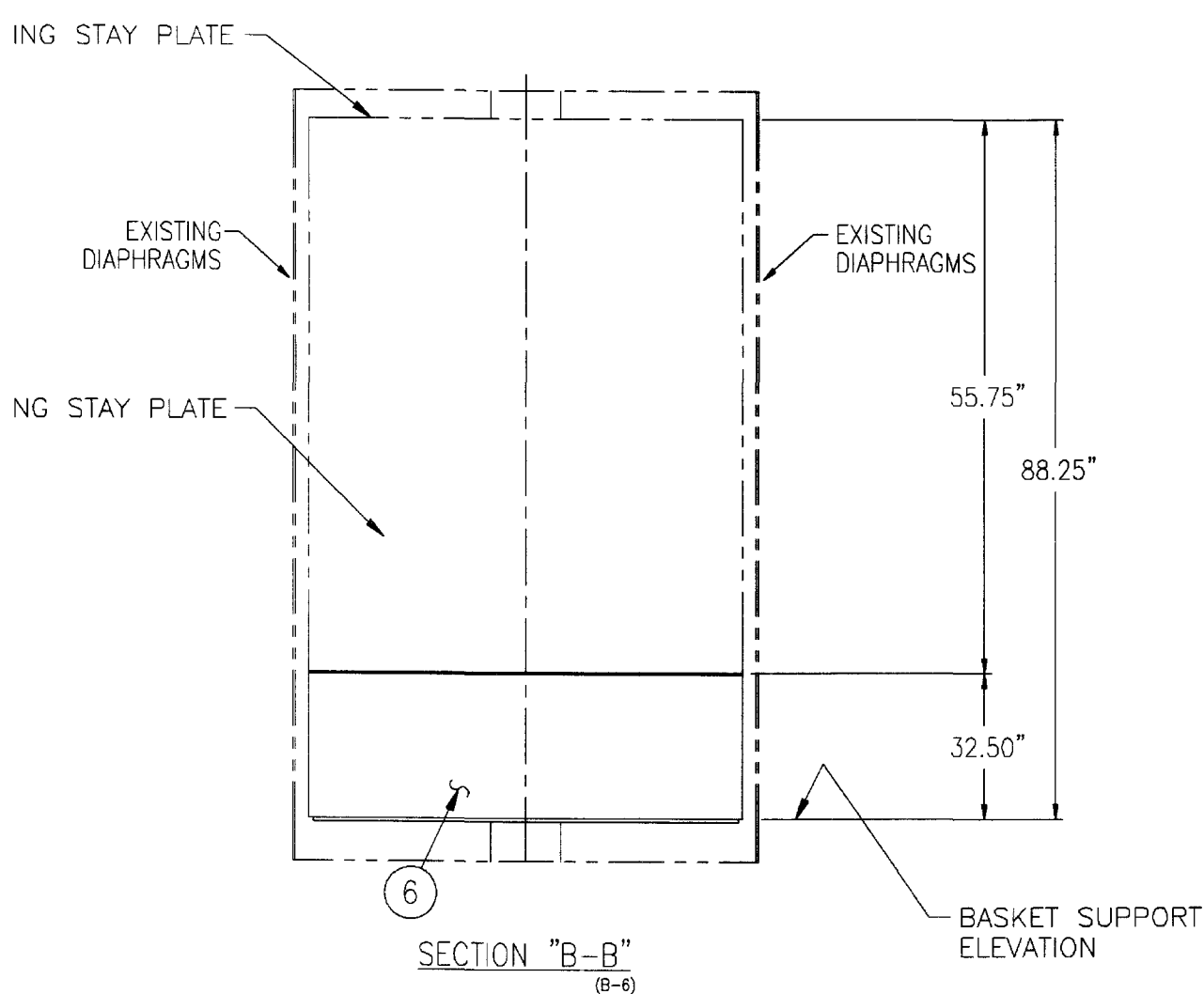
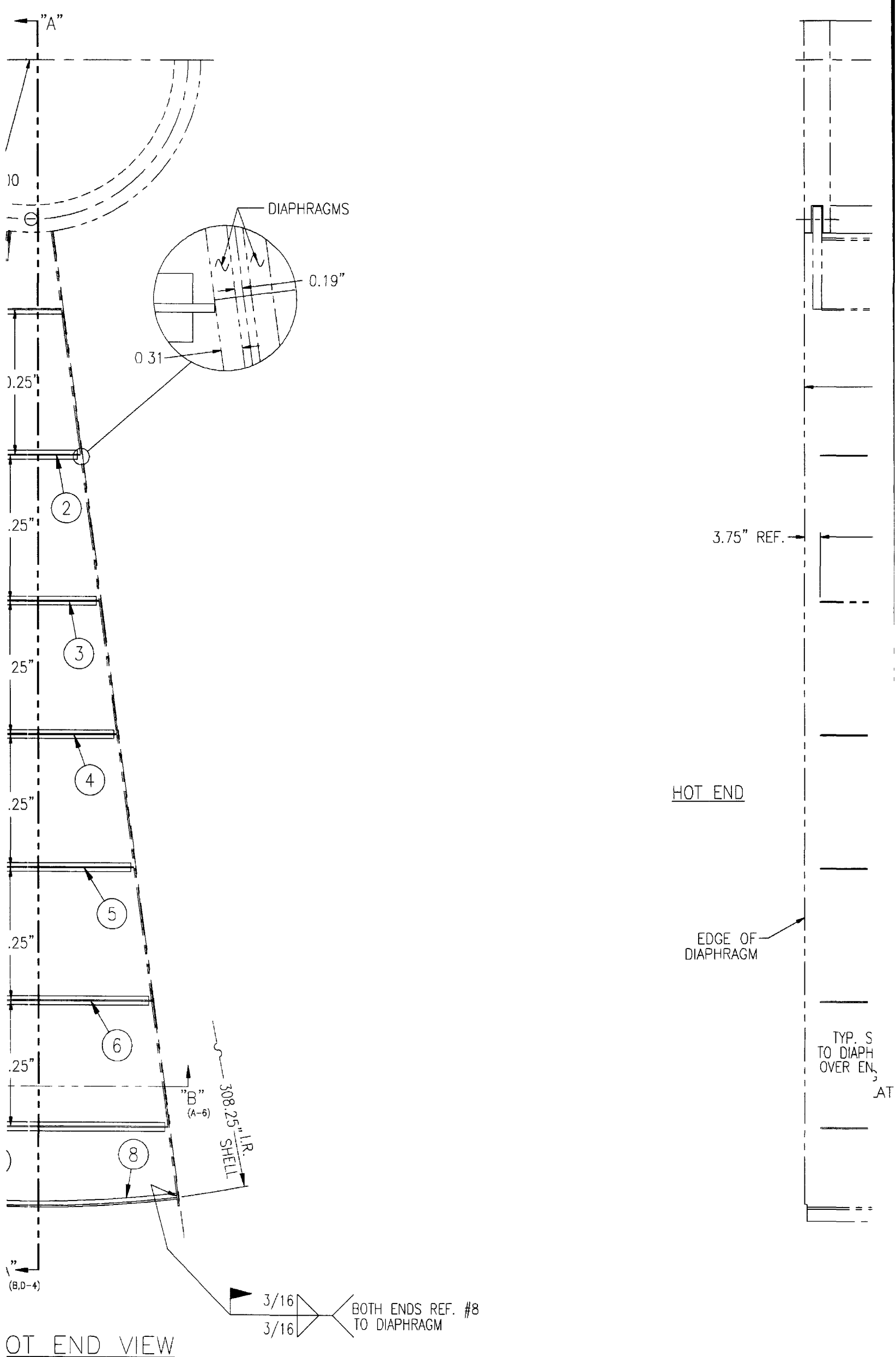
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		ALSTOM ALSTOM Power Inc. Air Preheater Company Wellsville, New York					
SUBJECT AIR PREHEATER		CLEARFLOW ROTOR MODIFICATIONS					
API NO.							
SIZE 33.5 VI MOD							
DR CJC	ck DV	CODE ER	GROUP 0100	SIZE D	DWG NO. 10031472	REV A	
APPR. BY							
DATE 12/11/03		SCALE NTS		WT	SHEET OF		



TYP. 3/16 3-9 3/16 3-9



SUPERSEDES SUPERSEDED BY



D

C

B

A

MEASURED TO
END OF LUG

1

16.13"

23.81"
REF.

33.38"
REF.

0.25"

43.00"
REF.

52.63"
REF.

62.25"
REF.

71.81"
REF.

79.50"

0.31"
DIAPHRAGM THICKNESS

CHORD DIM.
MEASURED ON
I.R. OF SHELL

PARTIAL H

TOP OF EXIS.

EXISTI

H				
G				
F				
E				
D				
C				
B				
A	8-3-04	WDS	DV	CHANGED FIELD WELD REQUIREMENT
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				

[4

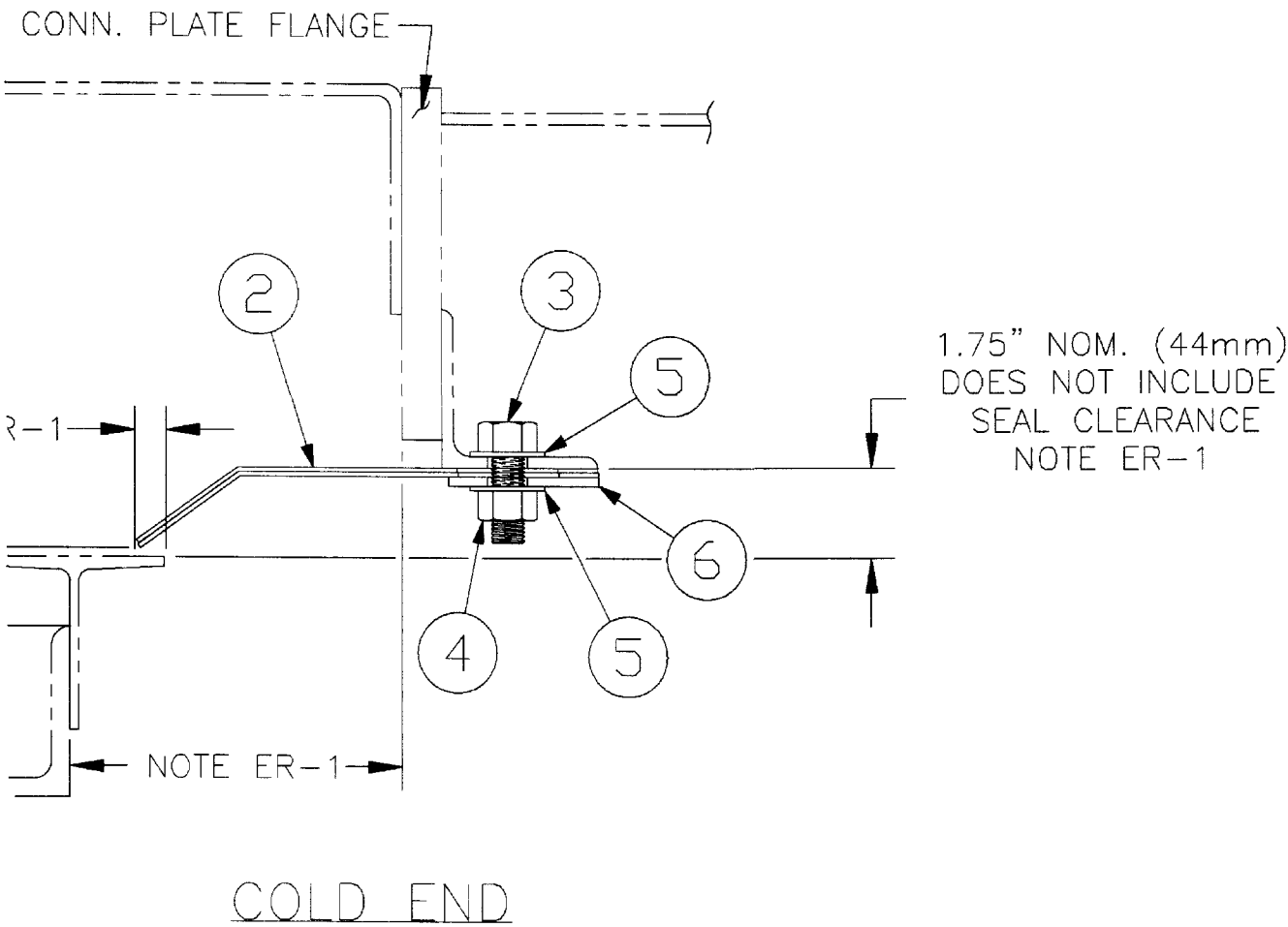
BILL OF MATERIAL

REF	DRAWING NO.	QTY.	MATL	DESCRIPTION	S.L.
1	B-99296	TAB "N"		BYPASS SEAL (HOT END) ASS'Y # "R" ARRGT #1	SL
2	B-99296	TAB "N"		BYPASS SEAL (COLD END) ASS'Y # "R" ARRGT #2	SL
3	P-12-25404	TAB "P"	3201	.63" X 1.5" HEX. HD. CAPSCREW	SL
4	P-10-25412	TAB "P"	3205	.63" FIN. HEX. NUT	SL
5	P-10-25413	TAB "Q"	3214	.63" WASHER	SL
6	E-67599	TAB "S"		BYPASS SEAL HOLDING STRIP	SL

NOTES TO ERECTOR:

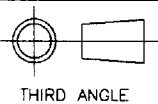
- ER-1 REFER TO SEAL INSTALLATION & SETTING DRAWING SPECIFIED IN GROUP 2106 AND GROUP 7000 SHEET.
- ER-2 LINE UP FIRST BYPASS SEAL WITH HOLES IN CONNECTING PLATE SEAL ANGLE. TRIM SEALS TO FIT AGAINST SEAL PLATE AND SECTOR PLATE.

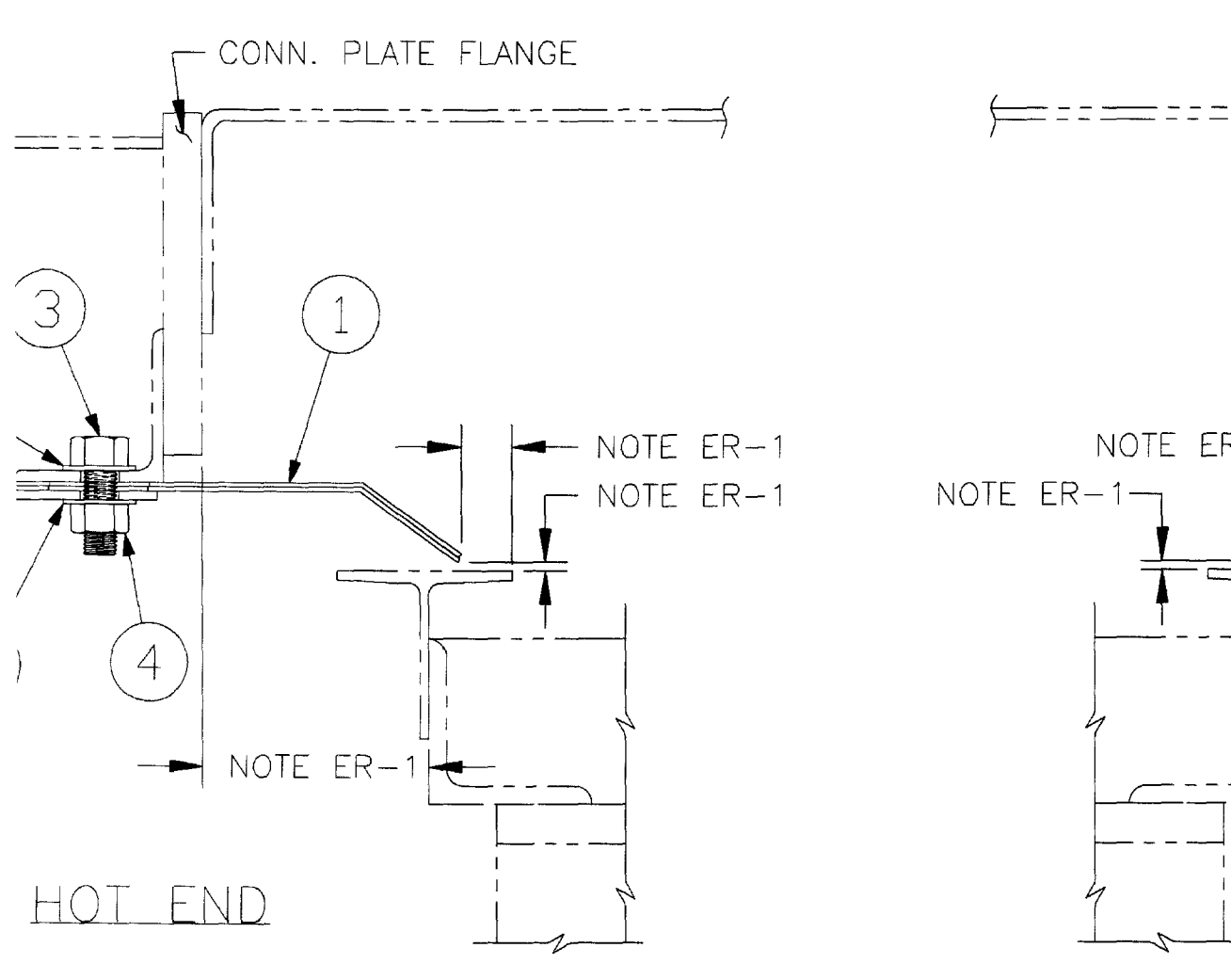
A



BYPASS SEAL

THIS DRAWING IS THE PROPERTY OF AIR PREHEATER COMPANY AND SHALL NOT BE REPRODUCED OR COPIED OR USED IN WHOLE OR IN PART TO FURNISH ANY INFORMATION FOR MAKING OF DRAWINGS OR FOR MANUFACTURE OR SALE OF EQUIPMENT REPRESENTED THEREON WITHOUT WRITTEN PERMISSION OF AIR PREHEATER COMPANY.

SUPERSEDED BY	ALL DIMENSIONS ARE IN INCHES UNLESS OTHER- WISE SPECIFIED	 THIRD ANGLE	ALSTOM ALSTOM Power Inc. Air Preheater Company Wellsville, New York					
	SUBJECT AIR PREHEATER		EE-ZEE(TM) BYPASS SEAL FIELD ASS'Y.					
SUPERSEDES	API NO.							
	SIZE V-VI-H							
	DR CRW	CK DPV	CODE	GROUP	SIZE	DWG NO.	REV	
	APPR. BY		ER	0505	C	99297	B	
	DATE 02-11-2000		SCALE NTS		WT		SHEET OF	



TYPICAL SECTION SHOWING BYF

TABULATION							
ASS'Y. NO.	HEATER SIZE	TAB "N"	TAB "P"	TAB "Q"	TAB "R"	TAB "S"	APPROX. WEIGHT
1	24.5	22	176	352	1	44	650#
2	25	22	176	352	2	44	650#
3	25 5	24	192	384	3	48	710#
4	26	24	192	384	4	48	710#
5	26.5	26	208	416	5	52	770#
6	27	26	208	416	6	52	770#
7	27.5	28	224	448	7	56	830#
8	28	28	224	448	8	56	830#
9	28 5	34	272	544	9	68	1040#
10	29	34	272	544	10	68	1040#
11	29.5	36	288	576	11	72	1100#
12	30	38	304	608	12	76	1160#
13	30.5	40	320	640	13	80	1220#
14	31	40	320	640	14	80	1220#
15	31.5	42	336	672	15	84	1280#
16	32	44	352	704	16	88	1345#
17	32.5	46	368	736	17	92	1525#
18	33	48	384	768	18	96	1590#
19	33 5	50	400	800	19	100	1665#
20	34	54	432	864	20	108	1790#
21	34.5	56	448	896	21	112	1900#
22	35	60	480	960	22	120	2023#
23	35.5	62	496	992	23	124	2090#
24	36	64	512	1024	24	128	2156#
25	29	34	272	544	25	68	1040#

H				
G				
F				
E				
D				
C				
B	8-3--04	DV	ACS	ADDED ARRGT TO REF #1 & 2 IN BILL OF MAT'L
A	3-6-03	JRC	JRC	REMOVED SEQ. NOTES, ADD ALSTOM BORDER
MARK	DATE	DR.	CK.	DESCRIPTION
ALTERATIONS				